

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
8 June 2006 (08.06.2006)

PCT

(10) International Publication Number
WO 2006/060801 A2

(51) International Patent Classification:
C09K 15/04 (2006.01) *C08G 61/12* (2006.01)
C08G 61/00 (2006.01)

(21) International Application Number:
PCT/US2005/044021

(22) International Filing Date:
2 December 2005 (02.12.2005)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:
60/632,893 3 December 2004 (03.12.2004) US

(71) Applicant (*for all designated States except US*): POLNOX CORPORATION [US/US]; 2nd Floor, Four Cambridge Center, Cambridge, MA 02142 (US).

(72) Inventors; and

(75) Inventors/Applicants (*for US only*): YANG, Suizhou [CN/US]; 61 East Meadow Lane, #5, Lowell, MA 01854 (US). CHOLLI, Ashok, L. [US/US]; 6 Rosemary Lane, Chelmsford, MA 01824 (US).

(74) Agents: PIERCE, N., Scott et al.; Hamilton, Brook, Smith & Reynolds P.C., 530 Virginia Road, P.O. Box 9133, Concord, MA 01742-9133 (US).

(81) Designated States (*unless otherwise indicated, for every kind of national protection available*): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KN, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, LY, MA, MD, MG, MK, MN, MW, MX, MZ, NA, NG, NL, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SM, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM, ZW.

(84) Designated States (*unless otherwise indicated, for every kind of regional protection available*): ARIPO (BW, GH, GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IS, IT, LT, LU, LV, MC, NL, PL, PT, RO, SE, SI, SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

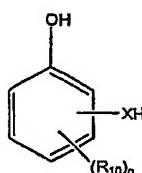
Published:

without international search report and to be republished upon receipt of that report

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

WO 2006/060801 A2

(54) Title: PROCESS FOR THE SYNTHESIS OF POLYALKYLPHENOL ANTIOXIDANTS



(57) Abstract: Disclosed is a method for the synthesis of sterically hindered polymeric antioxidants based on phenol type antioxidant monomers. The method includes partially etherifying, polymerizing and thermally rearranging a phenol containing monomer represented by the following structural formula (I): to produce a sterically hindered polymeric macromolecular antioxidant. X, R₁₀ and q are as defined herein. The disclosed method is a simple, direct and economical process for the synthesis of sterically hindered polymeric macromolecular antioxidants.

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PROCESS FOR THE SYNTHESIS OF POLYALKYLPHENOL ANTIOXIDANTS

RELATED APPLICATION

This application claims the benefit of U.S. Provisional Application No. 60/632,893, filed on December 3, 2004. The entire teachings of the above 5 application are incorporated herein by reference.

BACKGROUND OF THE INVENTION

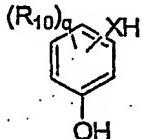
Many polymeric antioxidants possess significantly higher antioxidant activities compared to corresponding small molecule antioxidants, along with improved thermal stability and performance in a wide range of materials, for 10 example, plastics, elastomers, lubricants, petroleum based products (lubricants, gasoline, aviation fuels, and engine oils), cooking oil, cosmetics, processed food products, and the like.

The synthesis of polymeric phenol antioxidants (including sterically hindered polymeric phenol antioxidants) from substituted phenols, using a hydroxyl group protection/deprotection approach is described in patent applications to Cholli, *et al.*, including U.S. Provisional Application No.: 60/370,468, U.S. Patent Application Publication No.: 2003/230743, International Patent Publication No.s: WO 2003/87260, and WO 2005/071005, and U.S. Patent Application Serial No.: 10/408,679 the entire teachings of each of which are incorporated herein by 15 reference. These methods require multiple steps and purification of intermediates at each step. For example, WO 2003/87260 discloses a synthesis of poly (tert-butylhydroquinone) (poly(TBHQ)) that requires four separate steps, including separation of intermediate components at each step.

SUMMARY OF THE INVENTION

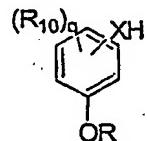
Disclosed is a method for the synthesis of sterically hindered polyalkylphenol antioxidants.

- The methods of the present invention include the first step of partially etherifying a phenol derivative represented by the following structural formula:



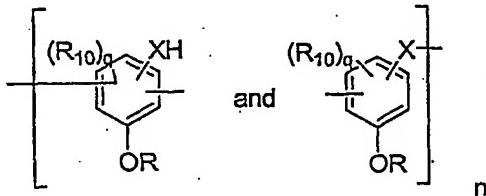
- At least one ring carbon atom substituted with an -OH group is adjacent to one unsubstituted ring carbon atom. X is -O-, -NH- or -S-. Each R₁₀ is independently an optionally substituted C1-C10 alkyl group, an optionally substituted aryl group, and optionally substituted alkoxy group, an optionally substituted carbonyl group, an optionally substituted alkoxy carbonyl group, an optionally substituted aryloxycarbonyl group, -OH, -SH or -NH₂; or two R₁₀ groups on adjacent carbon atoms join together to form an optionally substituted aromatic ring or an optionally substituted carbocyclic or heterocyclic non-aromatic ring. q is an integer from 0 to 2.

The etherification is carried out with an alkyl halide, alcohol or olefin and produces an alkoxy phenol derivative represented by the following structural formula:



- R is an optionally substituted C1-C10 alkyl group.

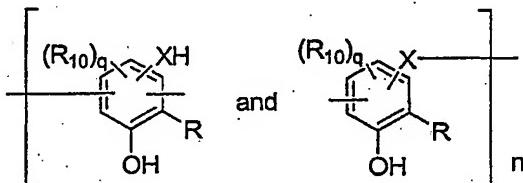
The methods of the present invention further include the second step of polymerizing the alkoxy phenol derivative to produce an alkoxy phenol polymer comprising at least one repeat unit selected from:



n is an integer greater than or equal to 2.

The methods further include the final step of thermally rearranging the alkyl portion of the alkoxy group of the polymer repeat units to the adjacent ring carbon atom to give a polymeric alkyl phenol derivative antioxidant comprising at least one

5 repeat unit selected from:



The present invention describes a simple, direct and economical process for the synthesis of polyalkylphenols as antioxidants. The methods of the invention 10 allow for the cost effective synthesis of polymeric antioxidants. Polymeric antioxidants made by the methods of the present invention in general possess significantly higher antioxidant activities along with improved thermal stability and performance in a wide range of materials including but not limited to plastics, elastomers, lubricants, petroleum based products (lubricants, gasoline, aviation fuels, 15 and engine oils), cooking oil, cosmetics, processed food products.

DETAILED DESCRIPTION OF THE INVENTION

A description of preferred embodiments of the invention follows.

The present invention is generally directed to methods of synthesizing sterically hindered phenol derived antioxidant polymers (polyalkylphenol 20 antioxidants).

Sterically hindered, as used herein means that the substituent group (e.g., bulky alkyl group) on a ring carbon atom adjacent (or *para*) to a ring carbon atom substituted with a phenolic hydroxy group (or thiol or amine group), is large enough to sterically hinder the phenolic hydroxy group (or thiol or amine groups). This 25 steric hinderance, in certain embodiments results in more labile or weak bonding between the oxygen and the hydrogen (or sulfur or nitrogen and hydrogen) and in turn enhances the stability and antioxidant activity (proton donating activity) of the sterically hindered antioxidant.

Such antioxidant polymers can be employed to inhibit the oxidation of an oxidizable material, for example by contacting the material with an antioxidant polymer made by the methods of the present invention.

For purposes of the present invention, a method of "inhibiting oxidation" is a 5 method that inhibits the propagation of a free radical-mediated process. Free radicals can be generated by heat, light, ionizing radiation, metal ions and some proteins and enzymes. Inhibiting oxidation also includes inhibiting reactions caused by the presence of oxygen, ozone or another compound capable of generating these gases or reactive equivalents of these gases.

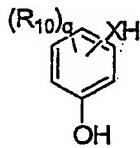
10 As used herein the term "oxidizable material" is any material which is subject to oxidation by free-radicals or oxidative reaction caused by the presence of oxygen, ozone or another compound capable of generating these gases or reactive equivalents thereof. In particular the oxidizable material is a lubricant or a mixture of lubricants.

15 Repeat units of the antioxidant polymers of the invention include substituted benzene molecules. These benzene molecules are typically based on phenol or a phenol derivative, such that they have at least one hydroxyl or ether functional group. In certain embodiments, the benzene molecules have a hydroxyl group. The hydroxyl group can be a free hydroxyl group and can be protected or have a 20 cleavable group attached to it (e.g., an ester group). Such cleavable groups can be released under certain conditions (e.g., changes in pH), with a desired shelf life or with a time-controlled release (e.g., measured by the half-life), which allows one to control where and/or when an antioxidant polymer can exert its antioxidant effect. The repeat units can also include analogous thiophenol and aniline derivatives, e.g., 25 where the phenol -OH can be replaced by -SH, -NH-, and the like.

Substituted benzene repeat units of an antioxidant polymer of the invention are also typically substituted with a bulky alkyl group or an n-alkoxycarbonyl group. In certain embodiments, the benzene monomers are substituted with a bulky alkyl group. In certain other embodiments, the bulky alkyl group is located *ortho* or *meta* 30 to a hydroxyl group on the benzene ring, typically *ortho*. A "bulky alkyl group" is defined herein as an alkyl group that is branched *alpha*- or *beta*- to the benzene ring. In certain other embodiments, the alkyl group is branched alpha to the benzene ring.

In certain other embodiments, the alkyl group is branched twice alpha to the benzene ring, such as in a *tert*-butyl group. Other examples of bulky alkyl groups include isopropyl, 2-butyl, 3-pentyl, 1,1-dimethylpropyl, 1-ethyl-1-methylpropyl and 1,1-diethylpropyl. In certain other embodiments, the bulky alkyl groups are 5 unsubstituted, but they can be substituted with a functional group that does not interfere with the antioxidant activity of the molecule or the polymer. Straight chained alkoxy carbonyl groups include methoxycarbonyl, ethoxycarbonyl, n-propoxycarbonyl, n-butoxycarbonyl and n-pentoxy carbonyl. N-propoxycarbonyl is a preferred group. Similar to the bulky alkyl groups, n-alkoxycarbonyl groups are 10 optionally substituted with a functional group that does not interfere with the antioxidant activity of the molecule or the polymer.

In certain embodiments, methods of the present invention include the first step of partially etherifying the phenol derivative represented by the following structural formula:



wherein at least one ring carbon atom substituted with an -OH, -SH or NH₂ group (e.g., >C-OH) is adjacent (or *ortho*) to one unsubstituted ring carbon atom (>C-H). In certain embodiments at least one ring carbon atom substituted with an -OH, -SH 15 or NH₂ group (e.g., >C-OH) is *meta* or *para* to one unsubstituted ring carbon atom (>C-H). X is -O-, -NH- or -S-. In certain embodiments X is -O-. Each R₁₀ is independently an optionally substituted C1-C10 alkyl group, an optionally substituted aryl group, and optionally substituted alkoxy group, an optionally substituted carbonyl group, an optionally substituted alkoxy carbonyl group, an 20 optionally substituted aryloxy carbonyl group, -OH, -SH or -NH₂ or two R₁₀ groups on adjacent carbon atoms join together to form an optionally substituted aromatic ring or an optionally substituted carbocyclic or heterocyclic non-aromatic ring. Additionally, when two R₁₀ groups on adjacent carbon atoms join together to form 25 an optionally substituted aromatic ring or an optionally substituted carbocyclic or heterocyclic non-aromatic ring, the optionally substituted aromatic ring or an 30 heterocyclic non-aromatic ring, the optionally substituted aromatic ring or an

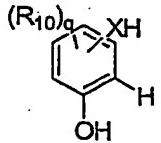
optionally substituted carbocyclic or heterocyclic non-aromatic ring may be further fused to another (i.e., a third) optionally substituted aromatic ring or an optionally substituted carbocyclic or heterocyclic non-aromatic ring. q is an integer from 0 to 2.

- 5 In certain embodiments, in structural formula 1, each R₁₀ is independently C1-C10 alkyl group, -OH, -SH or -NH₂, or two R₁₀ groups on adjacent carbon atoms join together to form an optionally substituted aromatic ring or an optionally substituted carbocyclic or heterocyclic non-aromatic ring. In certain other embodiments, two R₁₀ groups on adjacent carbon atoms join together to form an 10 optionally substituted non-aromatic heterocyclic ring. In certain embodiments the optionally substituted non-aromatic heterocyclic groups is optionally substituted tetrahydropyranyl or optionally substituted dihydropyranyl. In certain other embodiments the non-aromatic heterocyclic ring is optionally substituted with one or more substituents selected from the group =O, -OH, C1-C4 alkyl, optionally 15 substituted aryl, -OC(O)(C1-C4 alkyl), -OC(O)(aryl), -OC(O)(substituted aryl), -OC(O)(aralkyl), and -OC(O)(substituted aralkyl).

As used herein an unsubstituted ring carbon atom, is a ring carbon atom which is bonded to a hydrogen atom.

In one embodiment, the phenol derivative is represented by:

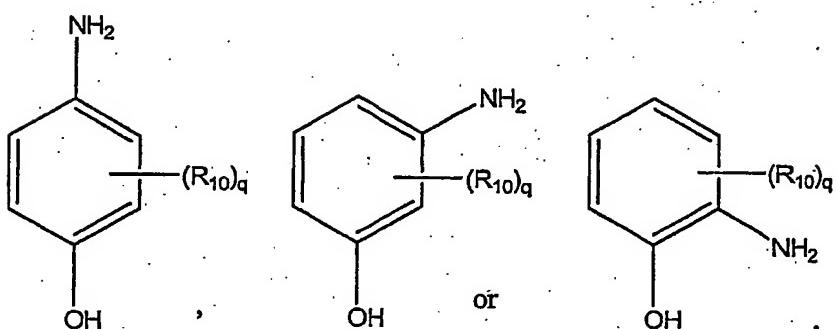
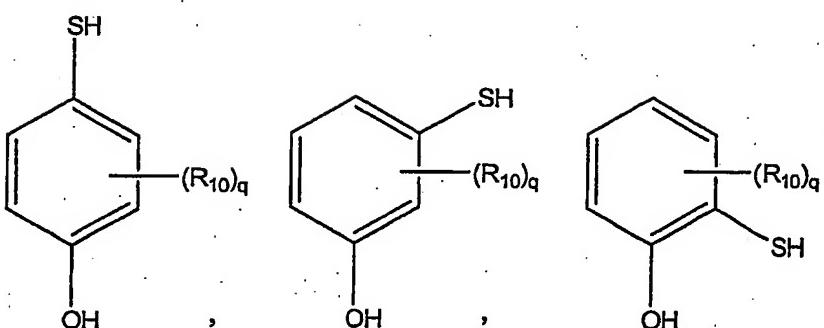
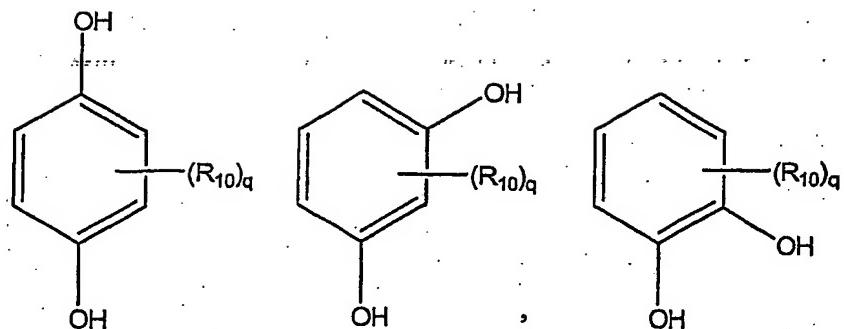
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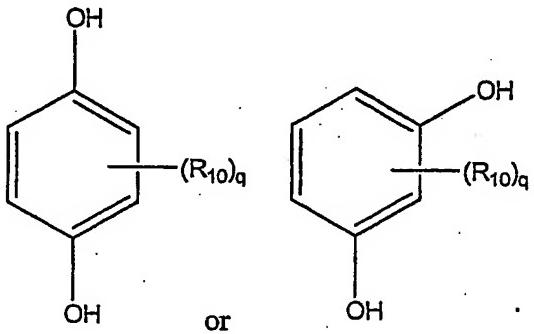
R₁₀, X and q are as described above.

- In certain embodiments, the methods of the present invention comprises partially etherifying an optionally substituted phenol derivative (for example, hydroquinone). In certain embodiments the optionally substituted phenol derivative 25 is represented by one of the following structural formulas:

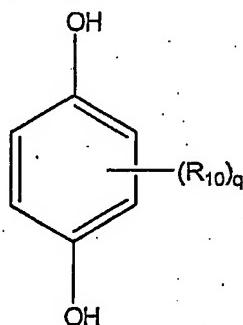
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In certain embodiments, the optionally substituted phenol derivative is represented by one of the following structural formulas:



In certain embodiments, the optionally substituted phenol derivative is represented by the following structural formula:



- 5 R_{10} and q are as defined above. Preferably each R_{10} is independently selected from the groups comprising an optionally substituted C1-C10 alkyl group, an optionally substituted aryl group, an optionally substituted alkoxy group, an optionally substituted alkoxy carbonyl group, an optionally substituted aryloxycarbonyl group, -OH, -SH or -NH₂. More preferably each R_{10} is
- 10 independently selected from the groups comprising a tertiary alkyl group (e.g., tert-butyl), an alkoxy carbonyl group or a hydroxy group. q is preferably 0 or 1.

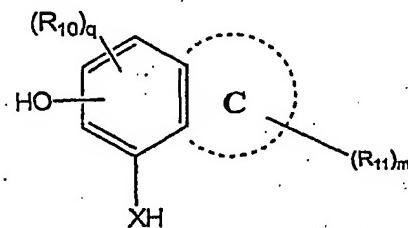
In certain embodiments each R_{10} is independently an optionally substituted C1-C10 alkyl group, an optionally substituted aryl group, and optionally substituted alkoxy group, an optionally substituted carbonyl group, an optionally substituted alkoxy carbonyl group, an optionally substituted aryloxycarbonyl group, -OH, -SH or -NH₂ or two R_{10} groups on adjacent carbon atoms join together to form an optionally substituted aromatic ring or an optionally substituted carbocyclic or heterocyclic non-aromatic.

15 In certain embodiments, each R_{10} is independently C1-C10 alkyl group, -OH, -SH or -NH₂, or two R_{10} groups on adjacent carbon atoms join together to form an optionally substituted aromatic ring or an optionally substituted carbocyclic or heterocyclic non-aromatic ring. In certain other embodiments, two R_{10} groups on adjacent carbon atoms join together to form an optionally substituted non-aromatic heterocyclic ring. In certain embodiments the optionally substituted non-aromatic 20 heterocyclic groups is optionally substituted tetrahydropyranol or optionally substituted dihydropyranol. In certain other embodiments the non-aromatic

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heterocyclic ring is optionally substituted with one or more substituents selected from the group =O, -OH, C1-C4 alkyl, optionally substituted aryl, -OC(O)(C1-C4 alkyl), -OC(O)(aryl), -OC(O)(substituted aryl), -OC(O)(aralkyl), and -OC(O)(substituted aralkyl).

- 5 In certain embodiments, the optionally substituted phenol derivative is represented by the following structural formula:



2

- 10 In certain embodiments, Ring C is a five or six membered aromatic or carbocyclic or heterocyclic non-aromatic ring. In certain other embodiments Ring C is a non-aromatic heterocyclic ring. In certain embodiments Ring C is tetrahydropyranyl or dihydropyranyl.

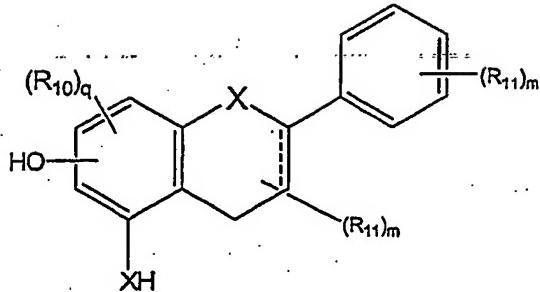
- 15 In certain embodiments each R₁₀ is independently C1-C10 alkyl group, -OH, -SH or -NH₂. q is 0 or 1.

- In certain other embodiments R₁₁ is =O, -OH, C1-C3 alkyl, optionally substituted aryl, -OC(O)(C1-C3 alkyl), -OC(O)(aryl), -OC(O)(substituted aryl), -OC(O)(aralkyl), or -OC(O)(substituted aralkyl). In certain other embodiments R₁₁ is =O, -OH, optionally substituted aryl or -OC(O)(aryl), -OC(O)(substituted aryl). In 20 certain other embodiments R₁₁ is =O, -OH, optionally substituted phenyl or -OC(O)(phenyl), -OC(O)(substituted phenyl). In certain other embodiments R₁₁ is =O, -OH, phenol, benzene-diol (pyrocatechol), benzene-triol, -OC(O)(phenol), -OC(O)(benzene-diol), or -OC(O)(benzene-triol).

m is an integer from 0 to 3.

- 25 In certain embodiments, the phenol derivative is represented by the following structural formula:

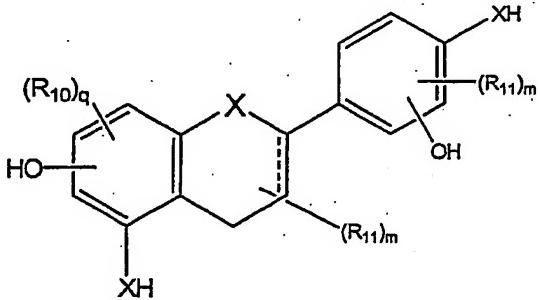
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3

The variables are as described above for structural formula 2. The dashed line represents a double or single bond.

5 In certain embodiments, optionally substituted phenol derivative is represented by the following structural formula:



4

The variables are as described above for structural formula 2. The dashed line represents a double or single bond.

10 In certain embodiments, the variables and descriptions for the optionally substituted phenol derivatives (phenol derivatives) described herein are as described above for structural formula 1.

15 In certain other embodiments the alkyl group which is added to the optionally substituted phenol derivative by etherification comprises a secondary or tertiary group comprising more than 3 carbon atoms. Preferably the alkyl group is a tertiary butyl group.

20 In certain embodiments the alkyl halide, alcohol or olefin (alkene) used for etherification can be selected from: alcohols (e.g., t-butanol, isobutanol etc.), alkenes (e.g., isobutene, styrene, diisobutylene, etc.), alkyl halides (e.g., 2-chloro-2-methylpropane, 2-bromo-2-methylpropane, 2-iodo-2-methylpropane, benzyl chloride, t-butyl chloride etc.).

Partially etherifying or mono-etherifying, as used herein means etherification at only one hydroxy substituent on the benzene ring. In the methods of the present invention the etherification step results in etherification of at least 50%, at least 60%, at least 70%, least 80%, at least 90% at least 95%, at least 99% or at least 100% of one hydroxy group on each benzene ring. In certain embodiments the etherification step results in etherification of 100% of one hydroxy group on each benzene ring, leaving the other functional (e.g., -OH, -SH or -NH₂) free for polymerization.

In certain embodiments of the present invention the etherification of the phenol derivative (e.g., hydroquinone, resorcinol and the like) is carried out in the presence of, for example, an alkyl halide (for example a tertiary alkyl halide, such as, 2-bromo-2-methylpropane, 2-chloro-2-methyl propane and 2-iodo-2-methylpropane etc.), an alcohol (for example a tertiary alcohol e.g., tert-butanol) or a corresponding olefin (such as isobutylene or propylene) in the presence of appropriate catalysts.

In certain embodiments of the present invention partial etherification is carried out in the presence of appropriate catalysts. In certain embodiments, when etherification is carried out in the presence of an alcohol or olefin, the catalysts is, for example, a strong inorganic acid, such as, hydrochloric acid, hydrobromic acid, sulfuric acid etc., a cationic exchange resin bearing sulfonic acid groups, metal halides, such as, aluminium chloride, zinc chloride and other acids. In certain other embodiments, when etherification is carried out in the presence of an alkyl halide the catalyst are, for example, a base, such as, pyridine, aliphatic amine (triethyl amine, trimethyl amine, diethyl amine etc.) and the like. The ratio of catalyst to monomer may vary from 0.1 to 100% with respect to the monomer.

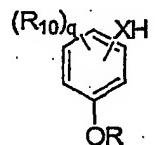
In certain embodiment, for the etherification in the presence of an alcohol or olefin, the reaction can be carried out without or with solvent. Organic solvents are typically polar solvents such as acetone, dioxane, tetrahydrofuran and so on. The temperature can be at about 0 °C or at elevated temperatures, such as from about 30 to 100 °C or from about 50 to 80 °C. For the reaction without solvent, the temperature can be from 100 to 400 °C or from 150 to 300 °C or even higher.

In certain embodiment, for the etherification in the presence of an alkyl halide, the reaction can be carried out with solvents such as dimethylformamide,

dioxane, acetonitrile, and diethyl ether. The temperature can be ranged from below 0 °C to elevated temperature of the system. The temperature can be at about 0 °C or at elevated temperatures, such as from about 30 to 100 °C or from about 50 to 80 °C.

In certain embodiments to get high yield of mono-etherification product, the 5 molar ratio of alcohol or olefin or alkyl halide with hydroquinone or resorcinol or the like should be more than 1, from 10:1 to 1:1, prefer 5:1 to 2:1.

In certain embodiments etherification of the optionally substituted phenol derivative results in an alkoxy phenol derivative represented by S:



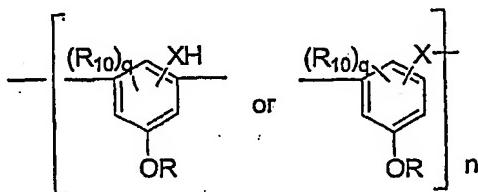
S

10 R₁₀, R, X, and q are as defined above. In certain embodiments wherein at least one ring carbon atom substituted with the -OR (or -NHR or -SR) group (e.g., >C-OR) is adjacent (or *ortho*) to one unsubstituted ring carbon atom (>C-H). In certain embodiments wherein at least one ring carbon atom substituted with the -OR (or -NHR or -SR) group (e.g., >C-OR) is *meta* or *para* to one unsubstituted ring 15 carbon atom (>C-H).

R is an optionally substituted C1-C10 alkyl group. Preferably R is a tert-butyl group.

20 In certain embodiments etherification can be carried out as described above to produce an aryloxy phenol derivative represented by S in which R is an optionally substituted aryl group.

In certain embodiments, the alkoxy phenol derivative is polymerized to produce a polymer represented by Structural Formula T.



T

R₁₀, R, X, n and q are as defined above. In certain embodiments at least one ring carbon atom substituted with the -OR (or -NHR or -SR) group (e.g., >C-OR) is adjacent (or *ortho*) to one unsubstituted ring carbon atom (>C-H). In certain embodiments wherein at least one ring carbon atom substituted with the -OR (or -

5 NHR or -SR) group (e.g., >C-OR) is *meta* or *para* to one unsubstituted ring carbon atom (>C-H).

An oxidative polymerization catalyst is added along with an oxidant, e.g., hydrogen peroxide or organic peroxide to convert the monomer to a polymer.

As used herein the oxidant serves as a substrate for the catalyst. The
10 oxidative polymerization catalyst and oxidant combined facilitate the oxidation of the monomer to form a polymer.

Polymerization of the monomers can be catalyzed by a natural or synthetic enzyme or an enzyme mimetic capable of polymerizing a substituted benzene compound in the presence of hydrogen peroxide, where the enzyme or enzyme
15 mimetic typically have a heme or related group at the active site. One general class of enzymes capable of catalyzing this reaction can be commonly referred to as the peroxidases. Horseradish peroxidase, soybean peroxidase, *Coprinus cinereus* peroxidase, and *Arthromyces ramosus* peroxidase are readily available peroxidases. Other enzymes capable of catalyzing the reaction include laccase, tyrosinase, and
20 lipases. Suitable enzymes are able to catalyze the formation of a carbon-carbon bond and/or a carbon-oxygen-carbon bond between two aryl (e.g., phenyl, phenol) groups when a peroxide (e.g., hydrogen peroxide or an organic peroxide) can be present. A subunit or other portion of a peroxidase can be acceptable, provided that the active site of the enzyme can be still functional. Enzyme mimetics typically
25 correspond to a part of an enzyme, so that they can carry out the same reaction as the parent enzyme but are generally smaller than the parent enzyme. Also, enzyme mimetics can be designed to be more robust than the parent enzyme, such as to be functional under a wider variety of conditions (e.g., different pH range, aqueous, particularly aqueous and non-aqueous solvents) and less subject to degradation or
30 inactivation. Suitable enzyme mimetics include hematin, tyrosinase-model complexes and iron-salen complexes. Hematin, in particular, can be functionalized to allow it to be soluble under a wider variety of conditions is disclosed in U.S.

Application No. 09/994,998, filed November 27, 2001, the entire teachings of which are incorporated herein by reference.

Polymerizations of the present invention can be carried out under a wide variety of conditions. The pH can be often between about pH 1.0 and about pH 5 12.0, typically between about pH 6.0 and about pH 11.0. The temperature can be above about 0°C, such as between about 0°C and about 100°C, 0°C and about 45°C or between about 15°C and about 30°C (e.g., room temperature). The solvent can be aqueous (preferably buffered), organic, or a combination thereof. Organic solvents are typically polar solvents such as ethanol, methanol, isopropanol,

10 dimethylformamide, dioxane, acetonitrile, and diethyl ether. The concentration of monomer or comonomers can be typically 0.001 M or greater. Also, the concentration of buffer can be typically 0.001 M or greater. The polymerization reaction is typically carried out for between 1 and 48 hours, between 10 and 40 hours, between 15 and 35 hours, or between 20 and 30 hours.

15 Polymerizations of the invention use a catalytic amount of one of the enzymes or enzyme mimetics described above, which can be between about one unit/mL and five units/mL, where one unit can form 1.0 mg purpurogallin from pyrogallol in 20 seconds at pH 6.0 at 20°C. Preferably, the enzyme or enzyme mimetic can be added to the solution after addition of the antioxidant monomer or 20 comonomers. A peroxide can be then added incrementally to the reaction mixture, such as not to de-activate the enzyme or enzyme mimetic, until an amount approximately stoichiometric with the amount of antioxidant monomer or comonomers has been added.

Although the enzyme or enzyme mimetic can be responsible for formation of 25 phenol-based free radicals needed for chain propagation, the coupling of radicals to form a polymer chain can be controlled by the phenoxy radical and solvent chemistries. Further details regarding the coupling of phenoxy radicals can be found in "Enzymatic catalysis in monophasic organic solvents," Dordick, J.S., *Enzyme Microb. Technol.* 11:194-211 (1989), the contents of which are incorporated herein 30 by reference. Coupling between substituted benzene monomers typically occurs ortho and/or para to a hydroxyl group. Coupling rarely occurs meta to a hydroxyl group.

Polymerization preferably results in the formation of C-C bonds. Preferred polymers can contain at least about 95% C-C bonds, at least about 90% C-C bonds, at least about 80% C-C bonds, at least about 70% C-C bonds, at least about 60% C-C bonds or at least about 50% C-C bonds. Especially preferred polymers contain 5 about 100% C-C bonds. The remaining bonds are typically C-O-C bonds.

In certain embodiments of the present invention addition of biocatalyst or biomimetic [horseradish peroxidase (HRP), soybean peroxidase, Iron(II)-salen, hematin, and other peroxidases] and hydrogen peroxide (drop wise addition) to the reaction mixture results in the polymerization of the monomer.

10 In certain other embodiments the polymerization is carried out in the presence of an inorganic or organometallic catalyst, such as ferric chloride, ammonium persulphate, Iron(III) chloride, Iron(III) bromide, aluminum chloride, zinc chloride, TEMPO, AIBN, bis(cyclopentadienyl)titanium dichloride, 2-di-alkyl-aluminum, chloride compounds, 3. triethyl aluminum and titanium tetra chloride, 15 4.Bis-Cyclopentadienyl, Zirconium Dichloride and 5 Ta(CH-t-Bu)(CH₂-t-Bu)₃.

In various embodiments, the monomer for the polymerization can be, for example, a derivative of phenol, aniline, benzenethiol, hydroquinone, mono-protected hydroquinone, aminophenol, 4-aminophenol, phloroglucinol, querectin, epicatechin, epigallocatechin, epicatechingallate and any other 20 polyphenolic, hydroxyl- aniline and hydroxyl-benezethiol system having at least one free ortho-position relative to the phenolic hydroxyl, and their combinations.

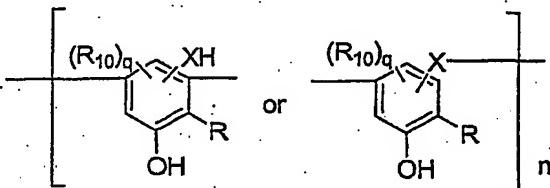
In various embodiments, the polymerization can be through, for example, a derivative of phenol, aniline and benzenethiol systems and their combinations.

25 In certain embodiments the present invention is a method for the synthesis of the macromolecules where the monomer for the polymerization could be, but is not limited to hydroquinone, mono-protected hydroquinone, 4-aminophenol, phloroglucinol, querectin, epicatechin, epigallocatechin, epicatechingallate and any other polyphenolic, hydroxyl- aniline and hydroxyl-benezethiol system having at least one free ortho-position with respect to the phenolic hydroxyl and their 30 combinations.

In certain embodiments of the present invention the alkyl (or aryl) portion of the phenyl ether in the resulting poly(alkoxy phenol derivative) (or poly(aryloxy

- 16 -

phenol derivative) is thermally rearranged to the ortho position. In certain embodiments the rearrangement occurs at elevated temperatures. In certain other embodiment the rearrangement occurs in the presence of a rearrangement catalyst. In certain embodiments the rearrangement creates an isomeric ortho polymeric alkyl 5 (or aryl) phenol derivative antioxidant represented by Structural Formula U.



U

R_{10} , R, X, n and q are as defined above.

As used herein thermal rearrangement is the displacement of the alkyl (or aryl) portion of an alkoxy (or aryloxy) group to the adjacent ring carbon atom under 10 elevated temperatures. As used herein elevated temperatures include from about 50 °C to bout 200 °C with alumina as a rearrangement catalyst, typically from about 65. °C to about 150 °C.

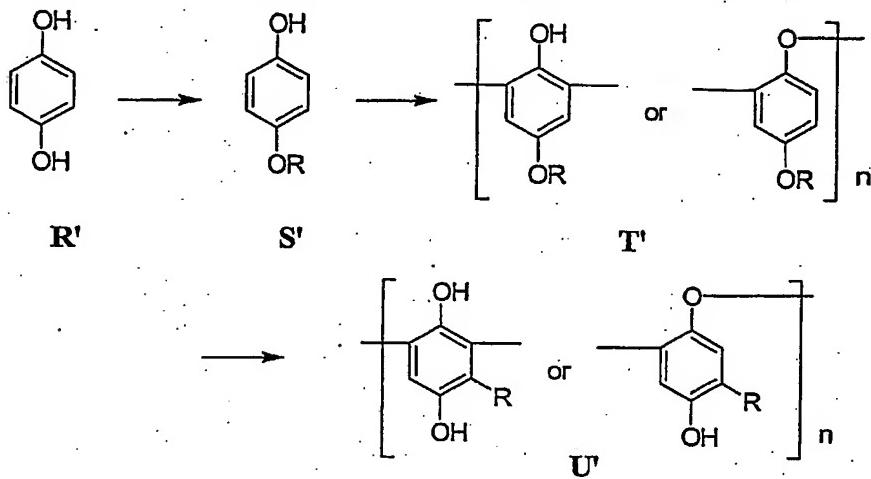
In the methods of the present invention the thermal rearrangement results in displacement of at least 50%, at least 60%, at least 70%, least 80%, at least 90% at 15 least 95%, at least 99% or at least 100% of the alkyl (or aryl) portion of the alkoxy (or aryloxy) group to the adjacent ring carbon atom. In certain embodiments the higher the displacement, the better - antioxidant properties of the polymer.

In certain embodiments, the rearrangement catalyst can be for example, hydrofluoric acid, silica gel, zeolites and the like. The solvents used for thermal 20 rearrangement normally should be inert to the catalyst. Examples of suitable solvents include toluene, xylene, hexane, heptane and the like. The ratio of catalyst may vary from 0.1 to 100 % by weight with respect to the ether unit to be rearranged.

In certain embodiments, for the optionally substituted phenol derivatives 25 (phenol derivatives) described herein the ring carbon atom substituted with an $-OH$, $-SH$ or NH_2 or an $-OR$ group ($>C-OR$) is not adjacent (or *ortho*) to one unsubstituted ring carbon atom ($>C-H$). In certain embodiments the polymers made by the present invention do not have a bulky alkyl group or aryl group adjacent to

the $-OH$, $-SH$ or NH_2 or $-OR$ $-SR$ or $-NHR$ group. In certain embodiments, in the polymers made by the methods of the present invention the bulky alkyl or aryl group is *meta* or *para* to the $-OH$, $-SH$ or NH_2 or OR $-SR$ or $-NHR$ group. Without wishing to be bound by any theory it is believed that presence of the bulky group *ortho*, *meta* or *para* to a hydroxy group (or amino or thiol group) increases the antioxidant activity of the compound. Preferably the bulky group is *ortho* to the hydroxy group (or amino or thiol group).

In certain embodiments the synthesis is represented as follows:

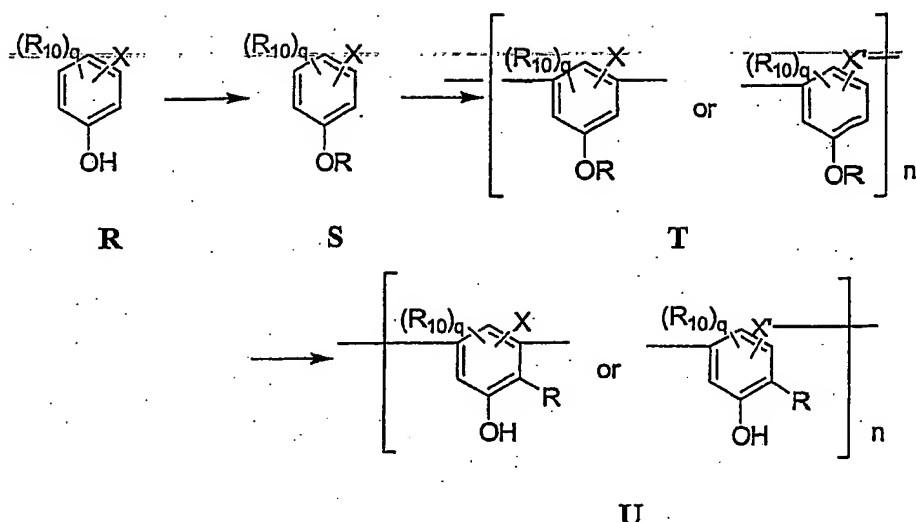


10 R is a C1-C10 alkyl group, an aryl group, or a benzyl group. In certain embodiments, R is a tertiary butyl group.

In certain embodiments the method comprises partially etherifying a phenol derivative (for example, hydroquinone) R with an alkyl halide, an alcohol (for example a tertiary alcohol) or a corresponding olefin in the presence of appropriate catalysts. The resulting alkoxyl phenol derivative S is polymerized using a biocatalyst or biomimetic catalyst to produce a polymer represented by Structural Formula T . Finally, the alkyl portion of the phenyl ether in the resulting poly(alkoxyl phenol derivative) is thermally rearranged to the *ortho* position in the presence of a rearrangement catalyst to give a polymeric alkyl phenol derivative 15 antioxidant represented by Structural Formula U .

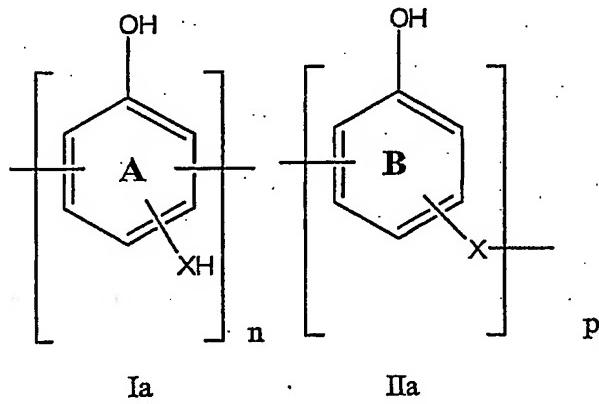
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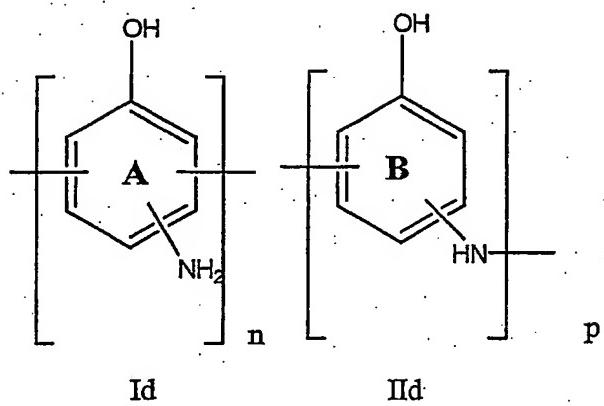
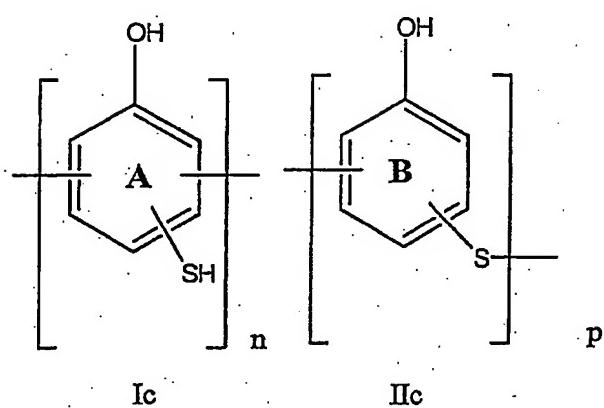
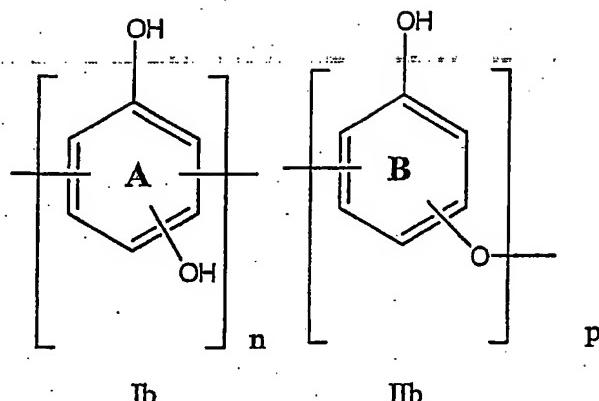


In Structural Formulas S, T, and U, n is an integer equal or greater than 2. X is -OH, -SH or -NH₂. X' is -O-, -S- OR -NH-. R is an optionally substituted C1-C10 alkyl group or an optionally substituted aryl group. Each R₁₀ is independently an optionally substituted C1-C10 alkyl group, an optionally substituted aryl group, and optionally substituted alkoxy group, an optionally substituted carbonyl group, an optionally substituted alkoxy carbonyl group, an optionally substituted aryloxycarbonyl group, -OH, -SH or -NH₂ an optionally substituted aromatic ring or an optionally substituted carbocyclic or heterocyclic non-aromatic ring. q is an integer from 0 to 2.

In a specific embodiment, the antioxidant polymer prepared by the methods of the present invention is represented by one or both of Structural Formulas (Ia) – (Id), and (IIa) – (IId):



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Ring A is substituted with at least one bulky alkyl group preferably a *tert*-butyl group ortho to the phenolic hydroxy group, and ring A is optionally further substituted with one or more groups selected from a substituted or unsubstituted alkyl or aryl group and a substituted or unsubstituted alkoxy carbonyl group. Ring A is further optionally fused to at least one more optionally substituted aromatic or optionally substituted non-aromatic carbocyclic or heterocyclic group.

- 20 -

Ring B is substituted with at least one -H and at least one bulky group preferably a *tert*-butyl group ortho to the phenolic hydroxy group, and ring B is further optionally substituted with one or more groups selected from a substituted or unsubstituted alkyl or aryl group and a substituted or unsubstituted alkoxy carbonyl group. Ring B is further optionally fused to at least one more optionally substituted aromatic or optionally substituted non-aromatic carbocyclic or heterocyclic group.

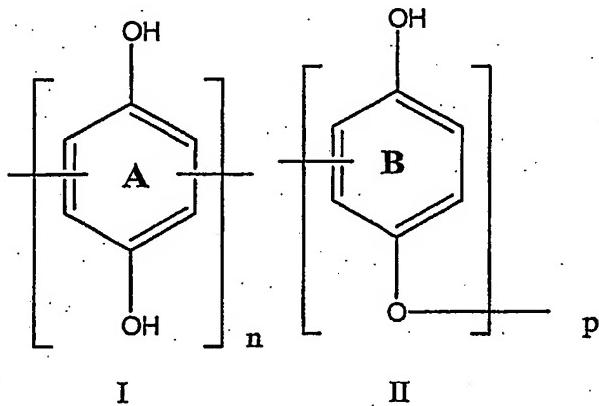
In various embodiments, the alkyl groups substituting Rings A and B can be, for example, secondary and tertiary alkyl groups containing 3 to 10 carbon atoms, typically between 3 and 6. In some embodiments, the alkyl groups are tertiary butyl groups.

X is -O-, -S- or -NH-.

n is an integer equal to or greater than 2; and

p is an integer equal to or greater than 0, wherein the sum of n and p is an integer greater than or equal to 2.

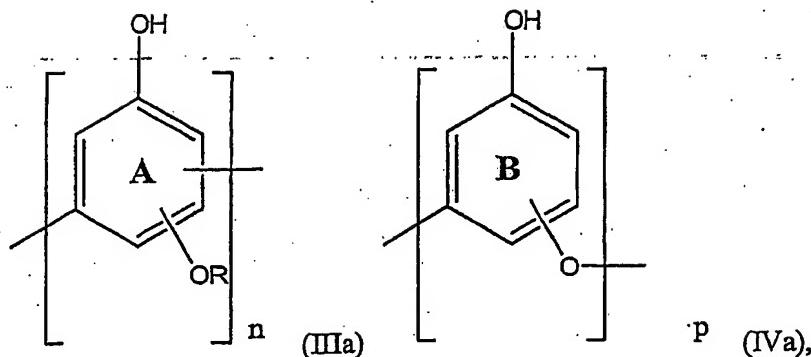
In another embodiment, the antioxidant polymer prepared by the methods of the present invention is represented by one or both of Structural Formulas (I), and (II):



where:

Ring A, Ring B, p and n are as described above

Preferred polymers synthesized by the methods of the present invention include repeat units represented by one or both of Structural Formulas (IIIa) and (IVa):

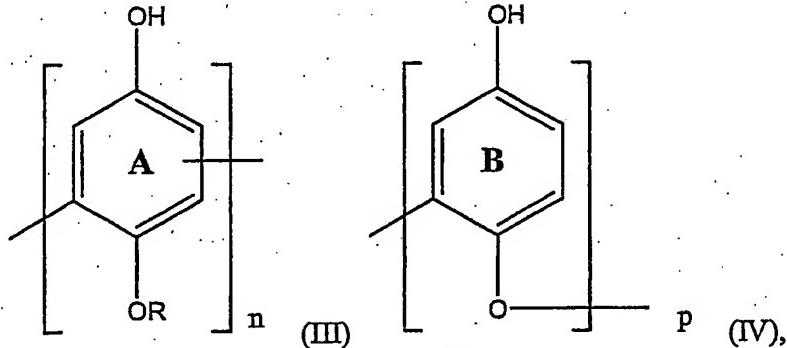


where Rings A and B are substituted as described above and n and p are as defined above.

Preferably, Ring A and Ring B in Structural Formulas (I) to (IV) are each substituted with at least one *tert*-butyl group located adjacent to the -OH.

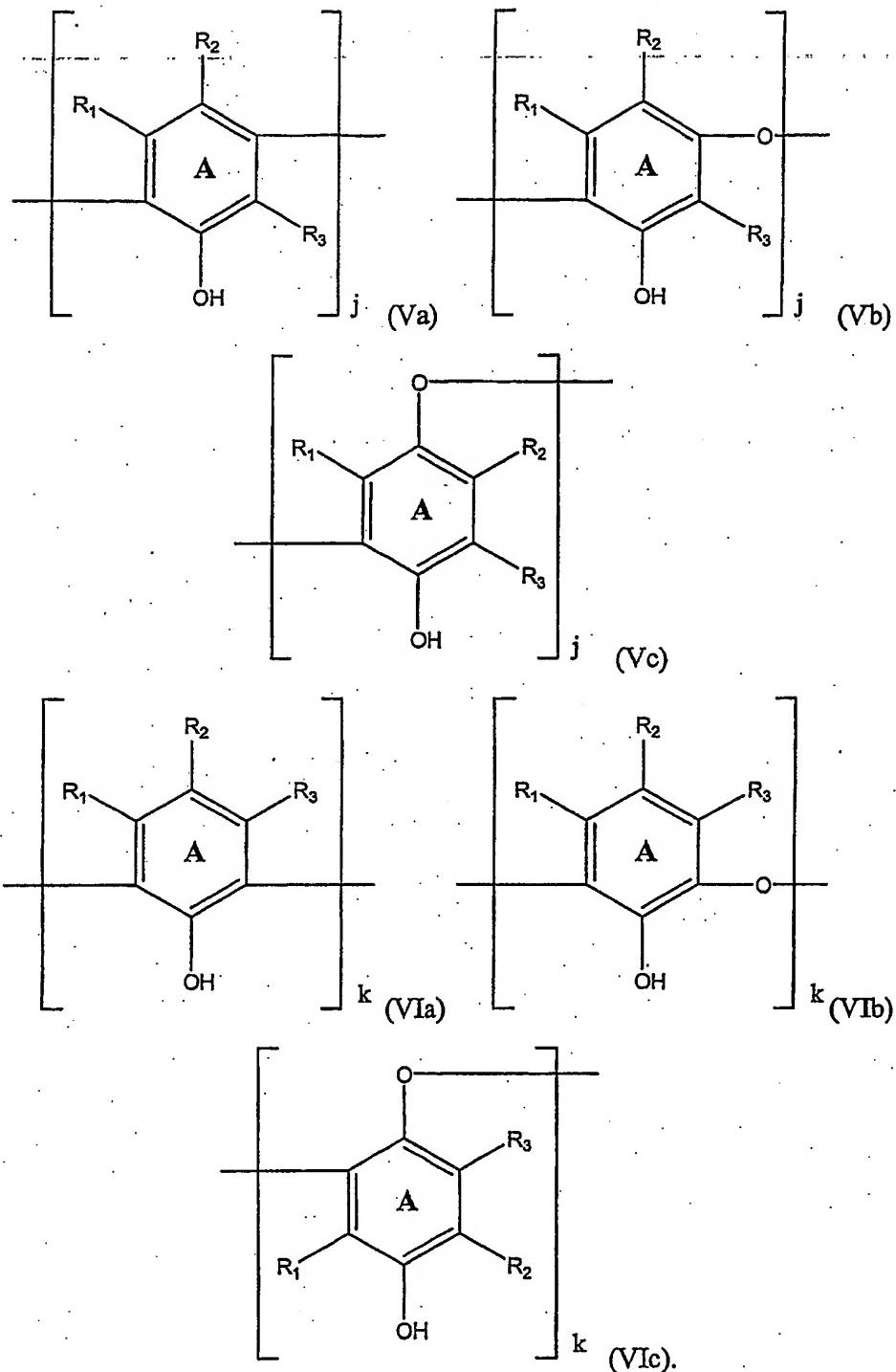
R is -H or -CH₃.

Preferred polymers synthesized by the methods of the present invention include repeat units represented by one or both of Structural Formulas (III) and (IV):



10 where Rings A and B are substituted as described above and R, n and p are as defined above.

The polymers made by the methods of the present invention can include repeat units represented by one or more of Structural Formulas (Va), (Vb), (Vc), (VIa), (VIb) and (VIc):



- 5 Where R₁, R₂ and R₃ are independently selected from the group consisting of -H, -OH, -NH, -SH, a substituted or unsubstituted alkyl or aryl group, and a substituted or unsubstituted alkoxy carbonyl group, additional values for R₁, R₂ and R₃ include carboxy and carbonyl. Preferably at least one of R₁, R₂ and R₃ is a *tert*-butyl group.

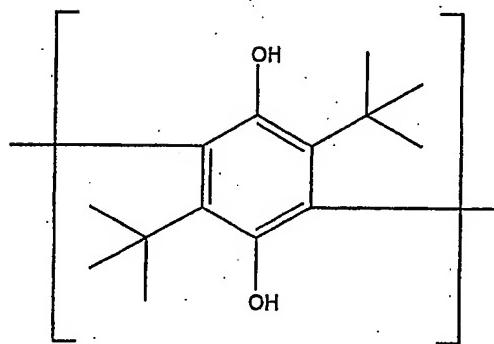
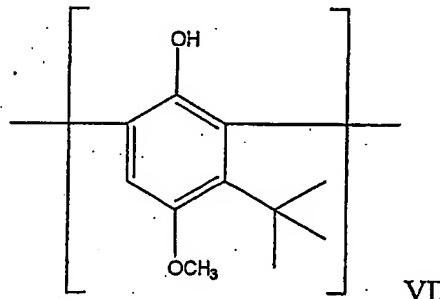
Preferably the *tert*-butyl group is adjacent to an -OH group; and j and k are independently integers of zero or greater, such that the sum of j and k is equal to or greater than 2. In certain embodiments, in structures Va and VIa at least one of R₁, R₂ and R₃ are independently -OH, -NH, -SH.

5 R is -H or -CH₃.

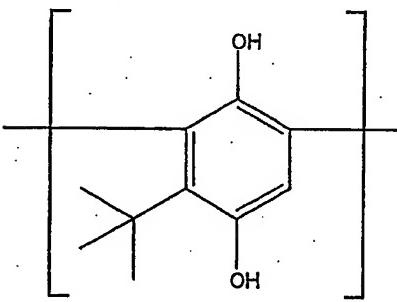
In a specific embodiment, R is -H or -CH₃; R₂ is -H, -OH, or a substituted or unsubstituted alkyl group; or both. Preferably R is -H.

Specific examples of repeat units included in polymers of the present invention are represented by one of the following structural formulas:

10

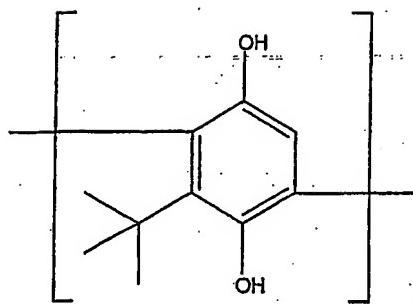


(VIII),

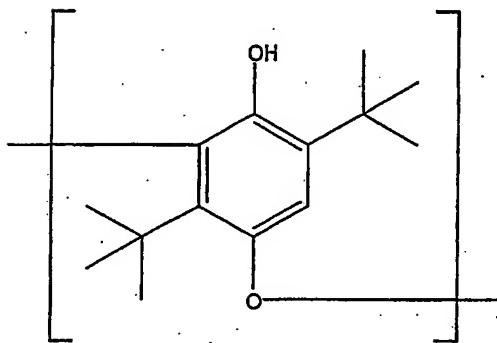


(IX),

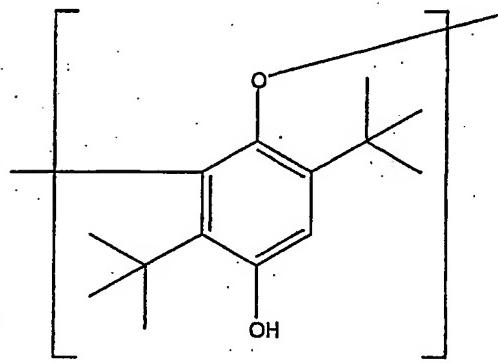
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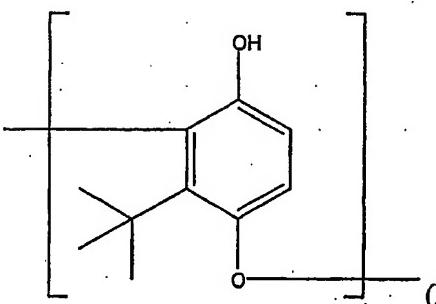
(X),



(XII),

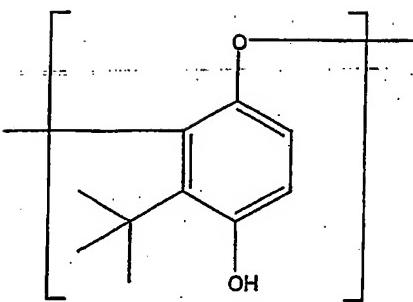


(XIII)

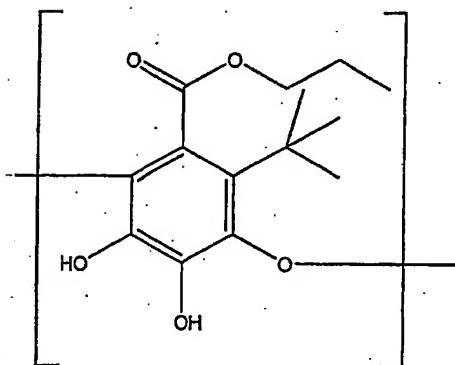


(XIV),

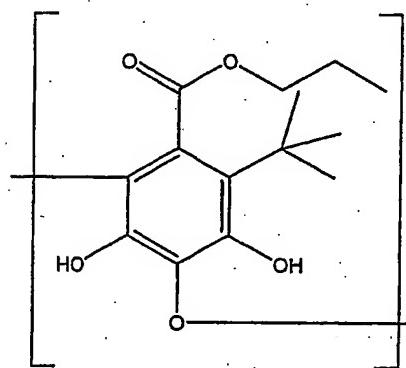
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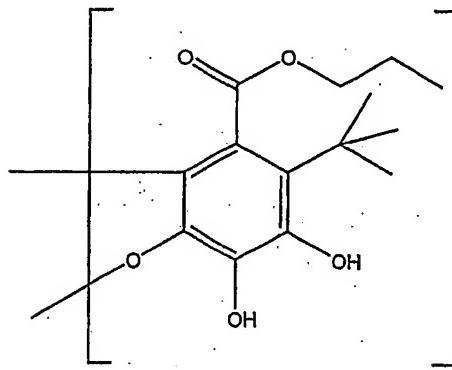
(XV),



(XVI)



(XVII), and

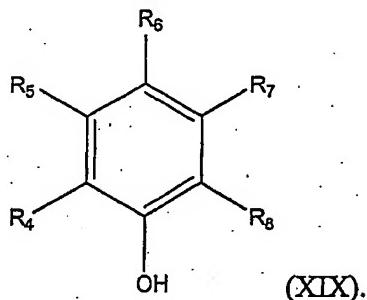


(XVIII).

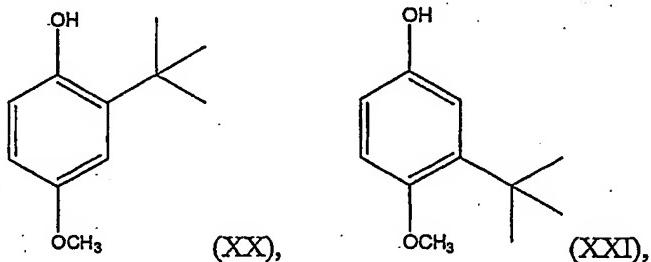
- 26 -

Advantageously, a polymer made by the methods of the present invention consists of repeat units represented by one or more of Structural Formulas (VII) to (XVIII).

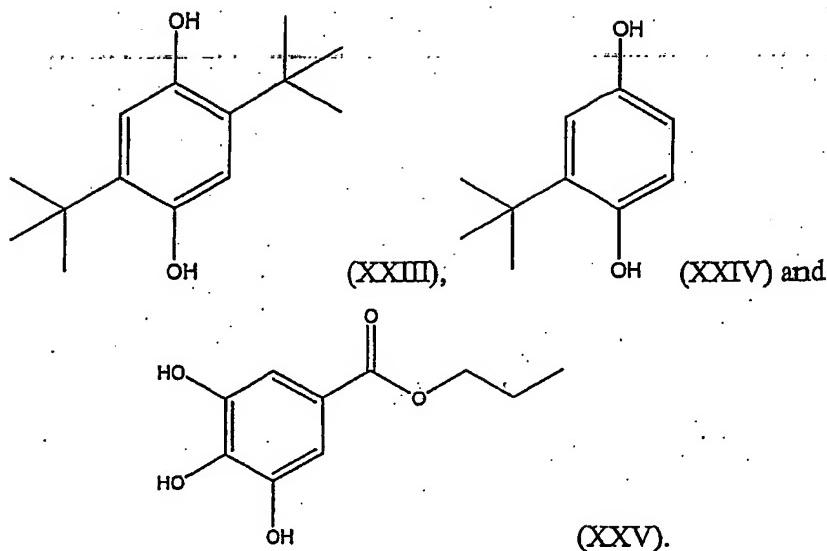
Antioxidant polymers made by the methods of the present invention are 5 prepared by polymerizing a molecule represented by Structural Formula (XIX):



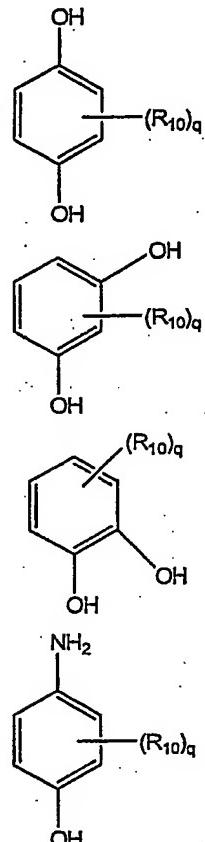
- In certain embodiments, XIX R₅-R₈ are independently selected from -OH, -SH, -NH₂, or -OH, -SH, -NH₂ wherein one hydrogen atom is replaced with a protecting group selected from alkyl, alkoxy, benzyl, benzoyl, THP, carbonate, acetal, ketal, 10 tretyl, dimethoxytretyl, trimethoxytretyl, silyl etc. Preferably, a molecule represented by Structural Formula (XIX) has one, two, three, four or five of the following features. In the first feature, at least one of R₅-R₈ are independently selected from -OH, -SH, -NH₂ and at least one of R₅, R₇ and R₈ is a *tert*-butyl group. In the second feature, R₄ is -H. In the third feature, one or both of R₇ and R₈ is -H. 15 In the fourth feature, R is -H or -CH₃. In the fifth feature, R₆ is -H, -OH or a substituted or unsubstituted alkyl group. More preferably, a molecule represented by Structural Formula (XIX) has the first and second features; the first, second and third features; the first, second, third and fourth features; or the first, second, third, fourth and fifth features.
- 20 Specific examples of monomers that can be polymerized to form an antioxidant polymer of the present invention are represented by one of the following structural formulas:



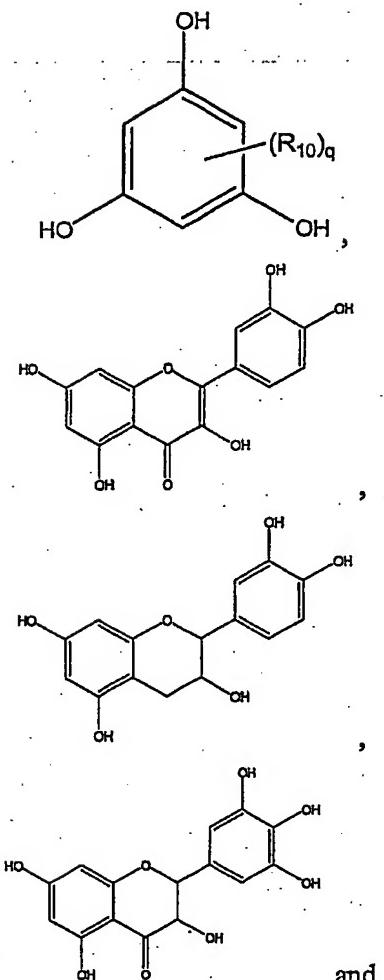
- 27 -



Other examples of specific monomers that can be polymerized to form an
5 antioxidant polymer of the present invention are represented by one of the following
structural formulas:

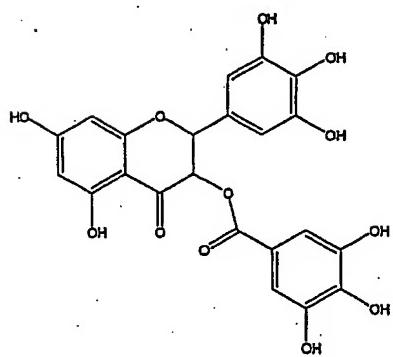


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and

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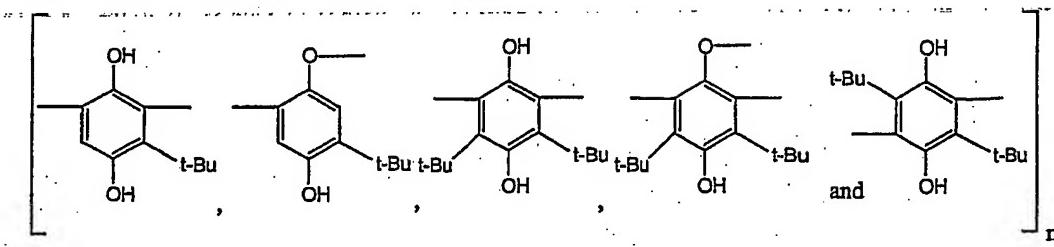
In all of the examples of monomers and polymers described herein the -OH groups can be replaced with OR, -NH₂, -NHR, -SH or -SR groups wherein R is as defined above.

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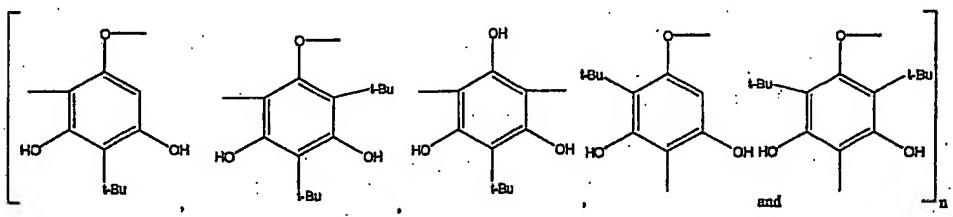
In certain embodiments, examples of sterically hindered polymeric macromolecular antioxidant produced by the methods of the present invention

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comprises at least one repeat unit selected from:

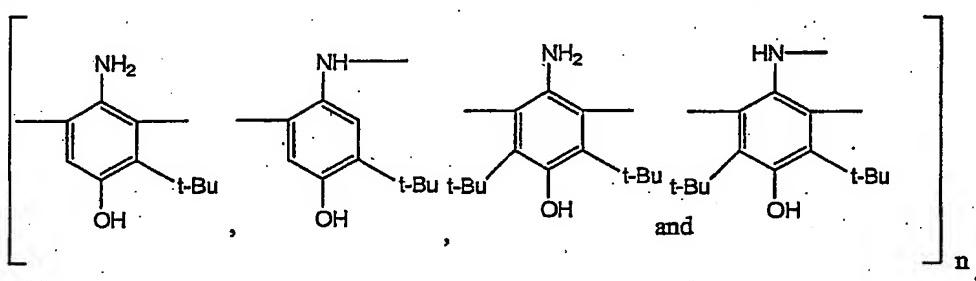


and

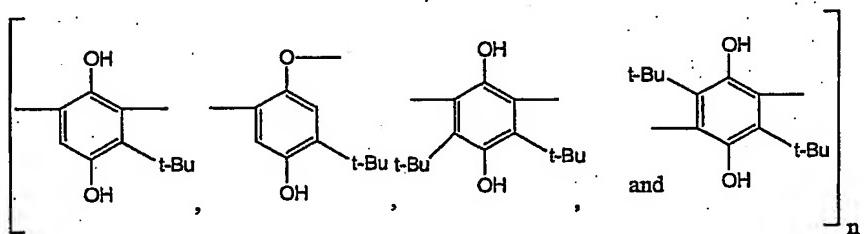


and

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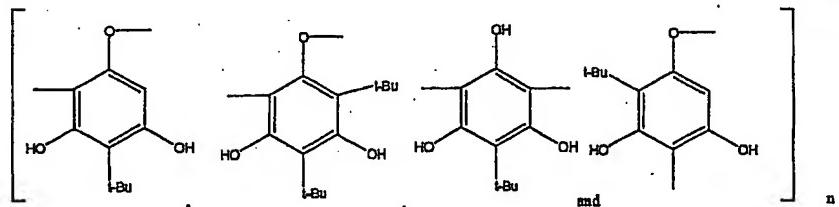


and



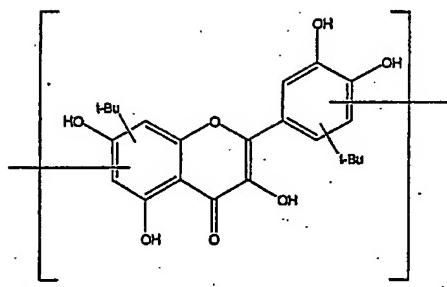
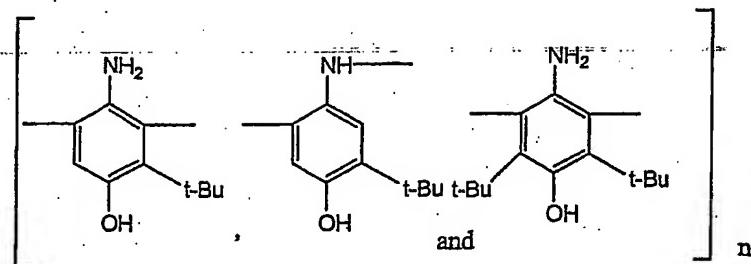
and

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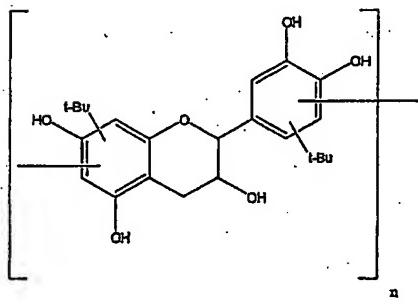
and

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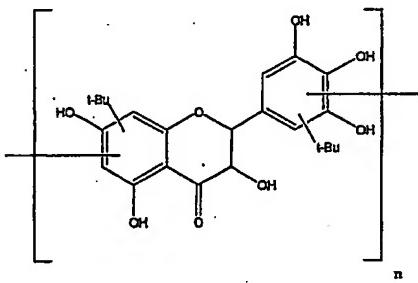


t-Butylated-polyQuercetin

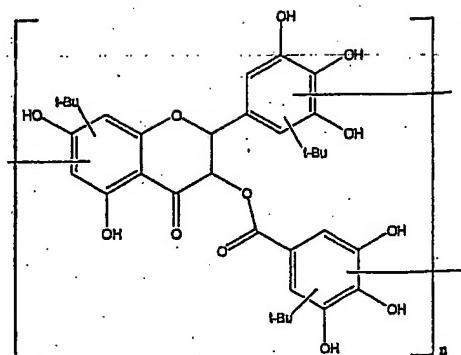
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t-Butylated-polyEpicatechin

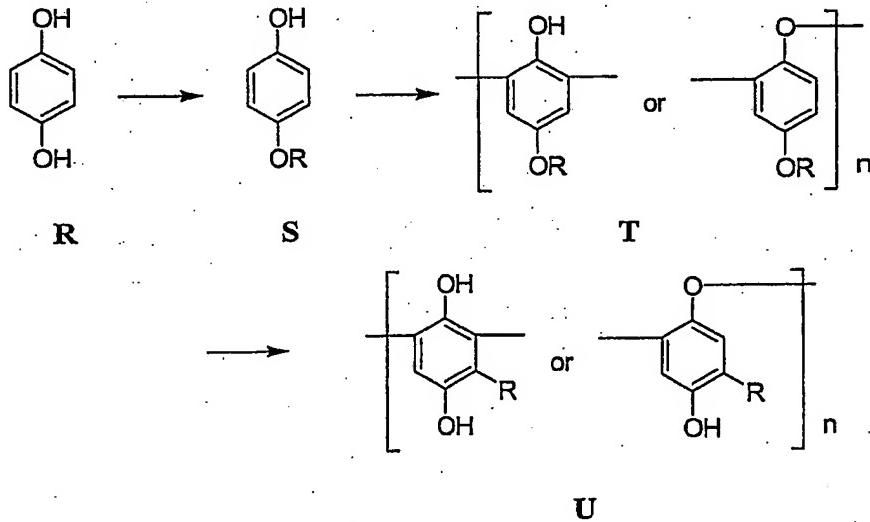


10 t-Butylated-polyEpigallocatechin and



t-Butylated-polyEpicatechin gallate.

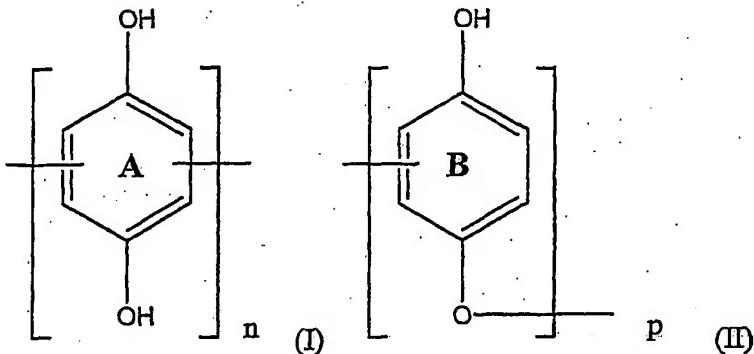
The method comprises partially etherifying optionally substituted hydroquinone R with an alkyl halide, an alcohol or a corresponding olefin in the presence of appropriate catalysts. The resulting alkoxyphenol S is polymerized using a biocatalyst or biomimetic catalyst to produce a polymer represented by Structural Formula T. Finally the alkyl phenyl ether moieties in the resulting poly(alkoxyphenol) undergo a thermal rearrangement to the ortho positions in the presence of a rearrangement catalyst to give a polyalkylphenol antioxidant represented by Structural Formula U.



In Structural Formulas S, T, and U, n is an integer equal or greater than 2. R is a C1-C10 alkyl group, an aryl group, or a benzyl group. Typically, R is a tertiary alkyl group, or in preferred embodiments, a tertiary butyl group.

The invention provides an economical process for preparing these antioxidant polymers.

In a preferred embodiment, the antioxidant polymer prepared by the method is represented by one or both of Structural Formulas (I) and (II):



where:

5 Ring A is substituted with at least one *tert*-butyl group, and optionally one or more groups selected from the group consisting of a substituted or unsubstituted alkyl or aryl group, and a substituted or unsubstituted alkoxy carbonyl group;

10 Ring B is substituted with at least one -H and at least one *tert*-butyl group and optionally one or more groups selected from the group consisting of - a substituted or unsubstituted alkyl or aryl group, and a substituted or unsubstituted alkoxy carbonyl group;

n is an integer equal to or greater than 2; and

p is an integer equal to or greater than 0.

15 In various embodiments, the alkyl groups substituting Rings A and B can be, for example, secondary and tertiary alkyl groups containing 3 to 10 carbon atoms, typically between 3 and 6. In some embodiments, the alkyl groups are tertiary butyl groups.

20 In various embodiments, the monomer for the polymerization can be formed, for example, by the etherification of hydroquinone, resorcinol and the like with an alkyl halide, an alcohol, an olefin and the like in the presence of appropriate catalysts.

25 In various embodiments, catalysts used for etherification can be, for example, acids, e.g. strong inorganic acids, a cationic exchange resin bearing sulfonic acid groups, metal halides, and other acids for the reaction of phenol with an alcohol or olefin; or bases, e.g., pyridine, aliphatic amines or other bases for the reaction of phenol with an alkyl halide.

In various embodiments, catalysts used for oxidative polymerization can be, for example, Iron(II)-salen, horseradish peroxidase (HRP), soybean peroxidase (SBP), hematin, and other peroxidase or biomimetic catalysts, and the like.

5 In various embodiments, catalysts used for rearranging alkoxyphenyl moieties in the poly(alkoxyphenol) to its isomeric ortho-alkyphenol moieties can be, for example, hydrofluoride acid, alumina, silica gel, zeolites and the like.

Antioxidant polymers made by the methods of the present invention have two or more repeat units, preferably greater than about five repeat units. The molecular weight of the polymers disclosed herein can be generally selected to be 10 appropriate for the desired application. Typically, the molecular weight can be greater than about 500 atomic mass units (amu) and less than about 2,000,000 amu, greater than about 1,000 amu and less than about 100,000 amu, greater than about 2,000 amu and less than about 10,000 amu, or greater than about 2,000 amu and less than about 5,000 amu. For food or edible products (e.g., products fit for human 15 consumption), the molecular weight can be advantageously selected to be large enough so that an antioxidant polymer cannot be absorbed by the gastrointestinal tract, such as greater than 1,000 amu. For antioxidant polymers blended with a polymeric material, the molecule weight can be advantageously selected such that the rate of diffusion of the antioxidant polymer through the polymeric material can 20 be slow relative to the expected lifetime of the polymeric material.

Antioxidant polymers made by the methods of the present invention can be either homopolymers or copolymers. A copolymer preferably contains two or more, or three or more, different repeating monomer units, each of which has varying or identical antioxidant properties. The identity of the repeat units in a copolymer can 25 be chosen to modify the antioxidant properties of the polymer as a whole, thereby giving a polymer with tunable properties. The second, third and/or further repeat units in a copolymer can be either a synthetic or natural antioxidant.

Antioxidant polymers made by the methods of the present invention are typically insoluble in aqueous media. The solubility of the antioxidant polymers in 30 non-aqueous media (e.g., oils) depends upon the molecular weight of the polymer, such that high molecular weight polymers are typically sparingly soluble in non-aqueous media. When an antioxidant polymer of the invention can be insoluble

in a particular medium or substrate, it can be preferably well-mixed with that medium or substrate.

Antioxidant polymers of the present invention can be branched or linear, but are preferably linear. Branched antioxidant polymers can only be formed from 5 benzene molecules having three or fewer substituents (e.g., three or more hydrogen atoms), as in Structural Formulas (XX), (XXI) and (XXIV).

Antioxidant polymers made by the methods of the present invention can be present in a wide variety of compositions where free radical mediated oxidation leads to deterioration of the quality of the composition, including edible products 10 such as oils, foods (e.g., meat products, dairy products, cereals, etc.), and other products containing fats or other compounds subject to oxidation. Antioxidant polymers can also be present in plastics and other polymers, elastomers (e.g., natural or synthetic rubber), petroleum products (e.g., fossil fuels such as gasoline, kerosene, diesel oil, heating oil, propane, jet fuel), lubricants, paints, pigments or 15 other colored items, soaps and cosmetics (e.g., creams, lotions, hair products). The antioxidant polymers can be used to coat a metal as a rust and corrosion inhibitor. Antioxidant polymers additionally can protect antioxidant vitamins (Vitamin A, Vitamin C, Vitamin E) and pharmaceutical products from degradation. In food products, the antioxidant polymers can prevent rancidity. In plastics, the antioxidant 20 polymers can prevent the plastic from becoming brittle and cracking.

Antioxidant polymers of the present invention can be added to oils to prolong their shelf life and properties. These oils can be formulated as vegetable shortening or margarine. Oils generally come from plant sources and include 25 cottonseed oil, linseed oil, olive oil, palm oil, corn oil, peanut oil, soybean oil, castor oil, coconut oil, safflower oil, sunflower oil, canola (rapeseed) oil and sesame oil. These oils contain one or more unsaturated fatty acids such as caproleic acid, palmitoleic acid, oleic acid, vaccenic acid, elaidic acid, brassidic acid, erucic acid, nervonic acid, linoleic acid, eleosteric acid, alpha-linolenic acid, gamma-linolenic acid, and arachidonic acid, or partially hydrogenated or trans-hydrogenated variants 30 thereof. Antioxidant polymers of the present invention are also advantageously added to food or other consumable products containing one or more of these fatty acids.

The shelf life of many materials and substances contained within the materials, such as packaging materials, are enhanced by the presence of an antioxidant polymer of the present invention. The addition of an antioxidant polymer to a packaging material is believed to provide additional protection to the product contained inside the package. In addition, the properties of many packaging materials themselves, particularly polymers, are enhanced by the presence of an antioxidant regardless of the application (i.e., not limited to use in packaging). Common examples of packaging materials include paper, cardboard and various plastics and polymers. A packaging material can be coated with an antioxidant polymer (e.g., by spraying the antioxidant polymer or by applying as a thin film coating), blended with or mixed with an antioxidant polymer (particularly for polymers), or otherwise have an antioxidant polymer present within it. In one example, a thermoplastic such as polyethylene, polypropylene or polystyrene can be melted in the presence of an antioxidant polymer in order to minimize its degradation during the polymer processing. An antioxidant polymer can also be co-extruded with a polymeric material.

The term "alkyl" as used herein means a saturated straight-chain, branched or cyclic hydrocarbon. When straight-chained or branched, an alkyl group is typically C₁-C₈, more typically C₁-C₆; when cyclic, an alkyl group is typically C₃-C₁₂, more typically C₃-C₇ alkyl ester. Examples of alkyl groups include methyl, ethyl, *n*-propyl, *iso*-propyl, *n*-butyl, *sec*-butyl and *tert*-butyl and 1,1-dimethylhexyl.

The term "alkoxy" as used herein is represented by -OR**, wherein R** is an alkyl group as defined above.

The term "carbonyl" as used herein is represented by -C(=O)R**, wherein R** is an alkyl group as defined above.

The term "alkoxycarbonyl" as used herein is represented by -C(-O)OR**, wherein R** is an alkyl group as defined above.

The term "aromatic group" includes carbocyclic aromatic rings and heteroaryl rings. The term "aromatic group" may be used interchangeably with the terms "aryl", "aryl ring", "aromatic ring", "aryl group" and "aromatic group".

Carbocyclic aromatic ring groups have only carbon ring atoms (typically six to fourteen) and include monocyclic aromatic rings such as phenyl and fused polycyclic

aromatic ring systems in which a carbocyclic aromatic ring is fused to one or more aromatic rings (carbocyclic aromatic or heteroaromatic). Examples include 1-naphthyl, 2-naphthyl, 1-anthracyl and 2-anthracyl. Also included within the scope of the term "carbocyclic aromatic ring", as it is used herein, is a group in which an aromatic ring is fused to one or more non-aromatic rings (carbocyclic or heterocyclic), such as in an indanyl, phthalimidyl, naphthimidyl, phenanthridinyl, or tetrahydronaphthyl.

The term "heteroaryl", "heteroaromatic", "heteroaryl ring", "heteroaryl group" and "heteroaromatic group", used alone or as part of a larger moiety as in "heteroaralkyl" refers to heteroaromatic ring groups having five to fourteen members, including monocyclic heteroaromatic rings and polycyclic aromatic rings in which a monocyclic aromatic ring is fused to one or more other aromatic ring (carbocyclic or heterocyclic). Heteroaryl groups have one or more ring heteroatoms. Examples of heteroaryl groups include 2-furanyl, 3-furanyl, *N*-imidazolyl, 2-imidazolyl, 4-imidazolyl, 5-imidazolyl, 3-isoxazolyl, 4-isoxazolyl, 5-isoxazolyl, oxadiazolyl, oxadiazolyl, 2-oxazolyl, 4-oxazolyl, 5-oxazolyl, *N*-pyrazolyl, 3-pyrazolyl, 4-pyrazolyl, 5-pyrazolyl, *N*-pyrrolyl, 2-pyrrolyl, 3-pyrrolyl, 2-pyridyl, 3-pyridyl, 4-pyridyl, 2-pyrimidinyl, 4-pyrimidinyl, 5-pyrimidinyl, 3-pyridazinyl, 4-pyridazinyl, 2-thiazolyl, 4-thiazolyl, 5-thiazolyl, triazolyl, tetrazolyl, 2-thienyl, 3-thienyl, carbazolyl, benzothienyl, benzofuranyl, indolyl, quinolinyl, benzothiazole, benzooxazole, benzimidazolyl, isoquinolinyl and isoindolyl. Also included within the scope of the term "heteroaryl", as it is used herein, is a group in which an aromatic ring is fused to one or more non-aromatic rings (carbocyclic or heterocyclic).

The term non-aromatic heterocyclic group used alone or as part of a larger moiety refers to non-aromatic heterocyclic ring groups having three to fourteen members, including monocyclic heterocyclic rings and polycyclic rings in which a monocyclic ring is fused to one or more other non-aromatic carbocyclic or heterocyclic ring or aromatic ring (carbocyclic or heterocyclic). Heterocyclic groups have one or more ring heteroatoms, and can be saturated or unsaturated. Examples of heterocyclic groups include piperidinyl, piperizinyl, pyrrolidinyl, pyrazolidinyl, imidazolidinyl, tetrahydroquinolinyl, inodolinyl, isoindolinyl, tetrahydrofuranyl,

oxazolidinyl, thiazolidinyl, dioxolanyl, dithiolanyl, tetrahydropyranyl, dihydropyranyl, azepanyl and azetidinyl.

The term "heteroatom" means nitrogen, oxygen, or sulfur and includes any oxidized form of nitrogen and sulfur, and the quaternized form of any basic nitrogen.

- 5 Also the term "nitrogen" includes a substitutable nitrogen of a heteroaryl or non-aromatic heterocyclic group. As an example, in a saturated or partially unsaturated ring having 0-3 heteroatoms selected from oxygen, sulfur or nitrogen, the nitrogen may be N (as in 3,4-dihydro-2H-pyrrolyl), NH (as in pyrrolidinyl) or NR" (as in N-substituted pyrrolidinyl), wherein R" is a suitable substituent for the nitrogen atom
- 10 in the ring of a non-aromatic nitrogen-containing heterocyclic group, as defined below.

As used herein the term non-aromatic carbocyclic ring as used alone or as part of a larger moiety refers to a non-aromatic carbon containing ring which can be saturated or unsaturated having three to fourteen atoms including monocyclic and

15 polycyclic rings in which the carbocyclic ring can be fused to one or more non-aromatic carbocyclic or heterocyclic rings or one or more aromatic (carbocyclic or heterocyclic) rings.

- An optionally substituted aryl group as defined herein may contain one or more substitutable ring atoms, such as carbon or nitrogen ring atoms. Examples of
- 20 suitable substituents on a substitutable ring carbon atom of an aryl group include halogen (e.g., -Br, Cl, I and F), -OH, C1-C3 alkyl, C1-C3 haloalkyl, -NO₂, C1-C3 alkoxy, C1-C3 haloalkoxy, -CN, -NH₂, C1-C3 alkylamino, C1-C3 dialkylamino, -C(O)NH₂, -C(O)NH(C1-C3 alkyl), -C(O)(C1-C3 alkyl), -OC(O)(C1-C3 alkyl), -OC(O)(aryl), -OC(O)(substituted aryl), -OC(O)(aralkyl), -OC(O)(substituted aralkyl), -NHC(O)H, -NHC(O)(C1-C3 alkyl), -C(O)N(C1-C3 alkyl)₂, -NHC(O)O-(C1-C3 alkyl), -C(O)OH, -C(O)O-(C1-C3 alkyl), -NHC(O)NH₂, -NHC(O)NH(C1-C3 alkyl), -NHC(O)N(C1-C3 alkyl)₂, -NH-C(=NH)NH₂, -SO₂NH₂, -SO₂NH(C1-C3 alkyl), -SO₂N(C1-C3 alkyl)₂, NHSO₂H, NHSO₂(C1-C3 alkyl) and optionally substituted aryl. Preferred substituents on aryl groups are as defined throughout the specification. In certain embodiments aryl groups are unsubstituted.

Examples of suitable substituents on a substitutable ring nitrogen atom of an aryl group include C1-C3 alkyl, NH₂, C1-C3 alkylamino, C1-C3 dialkylamino,

-C(O)NH₂, -C(O)NH(C1-C3 alkyl), -C(O)(C1-C3 alkyl), -CO₂ R**, -C(O)C(O)R**, -C(O)CH₃, -C(O)OH, -C(O)O-(C1-C3 alkyl), -SO₂NH₂, -SO₂NH(C1-C3 alkyl), -SO₂N(C1-C3 alkyl)₂, NHSO₂H, NHSO₂(C1-C3 alkyl), -C(=S)NH₂, -C(=S)NH(C1-C3 alkyl), -C(=S)N(C1-C3 alkyl)₂, -C(=NH)-N(H)₂, -C(=NH)-NH(C1-C3 alkyl) and 5 -C(=NH)-N(C1-C3 alkyl)₂,

An optionally substituted alkyl group or non-aromatic carbocyclic or heterocyclic group as defined herein may contain one or more substituents. Examples of suitable substituents for an alkyl group include those listed above for a substitutable carbon of an aryl and the following: =O, =S, =NNHR**, =NN(R**)₂, 10 =NNHC(O)R**, =NNHCO₂ (alkyl), =NNHSO₂ (alkyl), =NR**, spiro cycloalkyl group or fused cycloalkyl group. R** in each occurrence, independently is -H or C1-C6 alkyl. Preferred substituents on alkyl groups are as defined throughout the specification. In certain embodiments optionally substituted alkyl groups are unsubstituted.

15 Further examples of suitable substituents on an alkyl, aryl or acyl group may include, for example, halogen (-Br, -Cl, -I and -F), -OR_a, -CN, -NO₂, -N(R_a)₂, -COOR_a, -CON(R_a)₂, -SO_kR_a (k is 0, 1 or 2) and -NH-C(=NH)-NH₂. An alkyl group can also have =O or =S as a substituent. Each R_a is independently -H, an 20 alkyl group, a substituted alkyl group, a benzyl group, a substituted benzyl group, an aryl group or a substituted aryl group. A substituted benzylic group or aryl group can also have an alkyl or substituted alkyl group as a substituent. A substituted alkyl group can also have a benzyl, substituted benzyl, aryl or substituted aryl group as a substituent. A substituted alkyl, substituted aryl or substituted acyl group can have more than one substituent.

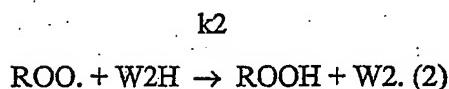
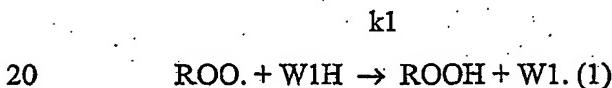
25 A "spiro cycloalkyl" group is a cycloalkyl group which shares one ring carbon atom with a carbon atom in an alkylene group or alkyl group, wherein the carbon atom being shared in the alkyl group is not a terminal carbon atom.

Without wishing to be bound by any theory or limited to any mechanism it is believed that macromolecular antioxidants and polymeric macromolecular 30 antioxidants of the present invention exploit the differences in activities (ks, equilibrium constant) of, for example, homo- or hetero- type antioxidant moieties. Antioxidant moieties include, for example, hindered phenolic groups, unhindered

phenolic groups, aminic groups and thioester groups, etc. of which there can be one or more present in each macromolecular antioxidant molecule. As used herein a homo-type antioxidant macromolecule comprises antioxidant moieties which are all same, for example, hindered phenolic, -OH groups. As used herein a hetero-type 5 antioxidant macromolecule comprises at least one different type of moiety, for example, hindered phenolic and aminic groups in the one macromolecule.

This difference in activities can be the result of, for example, the substitutions on neighboring carbons or the local chemical or physical environment (for example, due to electrochemical or stereochemical factors) which can be due in 10 part to the macromolecular nature of molecules.

In one embodiment of the present invention, a series of macromolecular antioxidant moieties of the present invention with different chemical structures can be represented by W₁H, W₂H, W₃H, to W_nH. In one embodiment of the present invention, two types of antioxidant moieties of the present invention can be represented by: W₁H and W₂H. In certain embodiments W₁H and W₂H can have rate constants of k₁ and k₂ respectively. The reactions involving these moieties and peroxy radicals can be represented as:



25 where ROO. is a peroxy radical resulting from, for example, initiation steps involving oxidation activity, for example:



30

In one particular embodiment of the present invention k₁ >> k₂ in equations (1) and (2). As a result, the reactions would take place in such a way that there is a

- 40 -

decrease in concentration of W1. free radicals due their participation in the regeneration of active moiety W2H in the molecule according equation (5):



5

This transfer mechanism may take place either in intra- or inter-molecular macromolecules. The transfer mechanism (5) could take place between moieties residing on the same macromolecule (intra-type) or residing on different macromolecules (inter-type).

10 In certain embodiments of the present invention, the antioxidant properties described immediately above (equation 5) of the macromolecular antioxidants and polymeric macromolecular antioxidants of the present invention result in advantages including, but not limited to:

- 15 a) Consumption of free radicals W1. according to equation (5) can result in a decrease of reactions of W1. with hydroperoxides and hydrocarbons (RH).
b) The regeneration of W1H provides extended protection of materials. This is a generous benefit to sacrificial type of antioxidants that are used today.
Regeneration of W1H assists in combating the oxidation process. The
20 increase in the concentration of antioxidant moieties W1H (according to equation 5) extends the shelf life of materials.

In certain embodiments of the present invention, the following items are of significant interest for enhanced antioxidant activity in the design of the
25 macromolecular antioxidants and polymeric macromolecular antioxidants of the present invention:

- a) The activity of proposed macromolecular antioxidant is dependent on the regeneration of W1H in equation (5) either through inter- or intra-molecular activities involving homo- or hetero-type antioxidant moieties.
b) Depending on the rates constants of W1H and W2H it is possible to achieve performance enhancements by many multiples and not just incremental improvements.
30

In certain embodiments of the present invention, more than two types of antioxidant moieties with different rate constants are used in the methods of the present invention.

The entire contents of each of the following are incorporated herein by reference.

- Docket No.: 3805.1001-000; Provisional Patent Application No.: 60/633,197, filed December 3, 2004, Title: Synthesis Of Sterically Hindered Phenol Based Macromolecular Antioxidants, by Ashish Dhawan, et al.;
- Docket No.: 3805.1001-001; filed December 2, 2005, Title: Synthesis Of Sterically Hindered Phenol Based Macromolecular Antioxidants, by Ashish Dhawan, et al.;
- Docket No.: 3805.1002-000; Provisional Patent Application No.: 60/633,252, filed December 3, 2004, Title: One Pot Process For Making Polymeric Antioxidants, by Vijayendra Kumar, et al.;
- 15 Docket No.: 3805.1002-001; filed December 2, 2005, Title: One Pot Process For Making Polymeric Antioxidants, by Vijayendra Kumar, et al.;
- Docket No.: 3805.1003-000; Provisional Patent Application No.: 60/633,196, filed December 3, 2004, Title: Synthesis Of Aniline And Phenol-Based Macromonomers And Corresponding Polymers, by Rajesh Kumar, et al.;
- 20 Docket No.: 3805.1003-001; filed December 2, 2005, Title: Synthesis Of Aniline And Phenol-Based Macromonomers And Corresponding Polymers, by Rajesh Kumar, et al.;
- Docket No.: 3805.1004-002; Patent Application No.: 11/184,724, filed July 19, 2005, Title: Anti-Oxidant Macromonomers And Polymers And Methods Of Making And Using The Same, by Ashok L. Cholli;
- 25 Docket No.: 3805.1004-005; Patent Application No. 11/184,716, filed July 19, 2005, Title: Anti-Oxidant Macromonomers And Polymers And Methods Of Making And Using The Same, by Ashok L. Cholli;
- Docket No.: 3805.1005-000; Provisional Patent Application No.: 60/655,169, filed 30 February 22, 2005, Title: Nitrogen And Hindered Phenol Containing Dual

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Functional Macromolecules: Synthesis And Their Antioxidant Performances
In Organic Materials, by Rajesh Kumar, et al.

- Docket No.: 3805.1006-000; Provisional Patent Application No.: 60/655,169, filed
March 25, 2005, Title: Alkylated Macromolecular Antioxidants And
5 Methods Of Making, And Using The Same, by Rajesh Kumar, et al.
- Docket No.: 3805.1007-000; Provisional Patent Application No. 60/731,125, filed
October 27, 2005, Title: Macromolecular Antioxidants And Polymeric
Macromolecular Antioxidants, by Ashok L. Cholli, et al.
- Docket No.: 3805.1008-000; Provisional Patent Application No. 60/731,021, filed
10 October 27, 2005, Title: Macromolecular Antioxidants Based On Sterically
Hindered Phenols And Phosphites, by Ashok L. Cholli, et al.
- Docket No.: 3805.1009-000; Provisional Patent Application, filed December 2,
2005, Title: Lubricant Composition, by Kumar, Rajesh, et al.
- Docket No.: 3805.1010-000; Provisional Patent Application No. 60/731,325, filed
15 October 27, 2005, Title: Stabilized Polyolefin Composition, by Kumar,
Rajesh, et al.
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2005, Title: Post-Coupling Synthetic Approach For Polymeric Antioxidants,
by Ashok L. Choll, et al.;
- 20 Docket No.: 0813.2006-002; Patent Application No.: PCT/US2005/001948, filed
January 21, 2005, Title: Post-Coupling Synthetic Approach For Polymeric
Antioxidants, by Ashok L. Cholli et al.;
- Docket No.: 0813.2002-008; Patent Application No.: PCT/US2005/001946, filed
January 21 2005, Title: Polymeric Antioxidants, by Ashok L. Choll, et al.;
- 25 Docket No.: 0813.2002-006; Patent Application No.: PCT/US03/10782, filed April
4, 2003, Title: Polymeric Antioxidants, by Ashok L. Choll, et al.;
- Docket No.: 0813.2002-004; Patent Application No.: 10/761,933, filed January 21,
2004, Title: Polymeric Antioxidants, by Ashish Dhawan, et al.;

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- Docket No.: 0813.2002-001; Patent Application No.: 10/408,679, filed April 4, 2003, Title: Polymeric Antioxidants, by Ashok L. Choll, et al.;
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- 15 New Heterogeneous Williamson Synthesis of Ethers Using tert-alkyl Substrates. Masada, Hiromitsu; Doi, Yasuo; Mikuchi, Fumio; Keiko, Kigoshi. Faculty Eng., Kanazawa Univ., Kanazawa, Japan. Nippon Kagaku Kaishi (1996), (3), 275-82.
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EXEMPLIFICATION

The formation of macromolecular antioxidant are illustrated with following
20 examples.

Example 1, Preparation of 4-(tert-butoxy)phenol

A mixture of 14.0 g of tert-butylbromide, 11.0 g of hydroquininone, 8 g of pyridine and 50 ml acetonitrile was stirred for 10 days at room temperature. The
25 solvent was removed by evaporation. The residue was washed with water three times to give 5.7 g of white crystalline product with melting point 152-4 °C. ¹H NMR (CDCl₃): δ 6.82-6.93 (m, 2H), 6.67-6.77 (m, 2H), 4.75 (s, 1H), 1.31 (s, 9H); ¹³C NMR (CDCl₃): δ 151.88, 148.78, 125.74, 115.52, 78.36, and 28.89.

30 Example 2, Preparation of poly(4-(tert-butoxy)phenol)

A mixture of 1.5 g of 4-(tert-butoxy)phenol, 60 ml tetrahydrofuran and 0.1 g of Fe-salen was stirred at room temperature. Hydrogen peroxide solution (1.5 ml

50% H₂O₂ water solution and 6 ml H₂O) was added dropwise to the mixture for two hours and the reaction was kept going at room temperature for 24 hours. The solvent was removed by evaporation. The residue was dissolved in 10 ml acetone and added into acidic ice water (PH=3). The precipitate was collected by filtration and dried to give brown powder product. Yield: 1.15 g.

Example 3, Preparation of poly(4-tert-butyl hydroquinone)

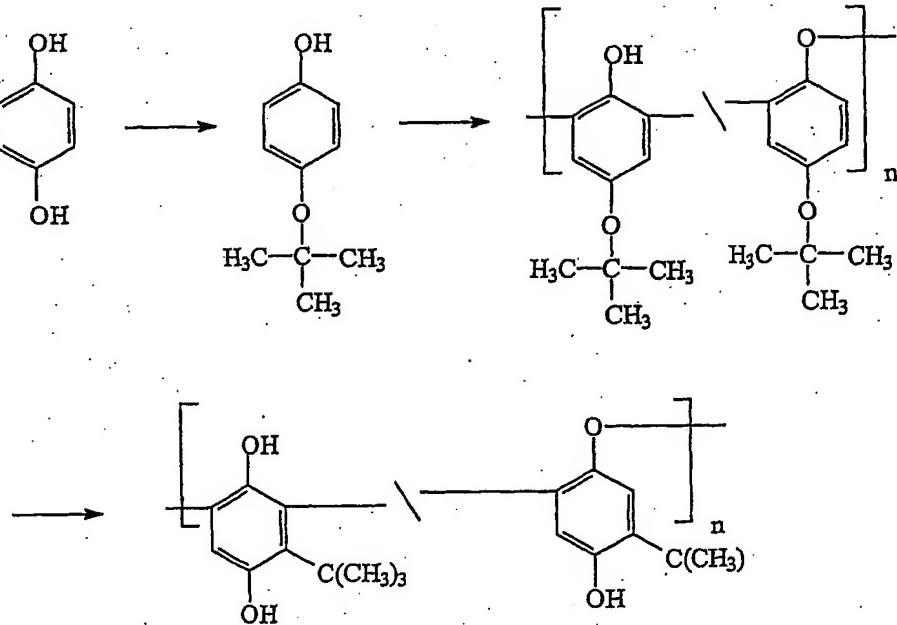
A. Preparation of thermal-rearrangement catalyst

10 gram alumina is added into 50 ml 1 M NH₄F water solution and the mixture is stirred for 2 hours. Then the precipitate is collected by filtration and dried at 200 °C for 24 hours to give fluorided alumina thermal-rearrangement catalyst.

B. Preparation of poly(4-tert-butyl hydroquinone)

15 A mixture of 1g of poly(4-(tert-butoxy)phenol), 0.5 g of fluorided alumina and 100 ml xylene is stirred and heated to reflux for 24 hours. The mixture is cooled down to room temperature and filtrated. The filtrate is concentrated to 10 ml by evaporation and added dropwise to ice water. The precipitate is collected by filtration and dried.

20 Scheme 1



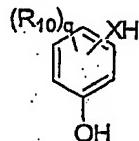
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While this invention has been particularly shown and described with references to preferred embodiments thereof, it will be understood by those skilled in the art that various changes in form and details may be made therein without departing from the scope of the invention encompassed by the appended claims.

CLAIMS

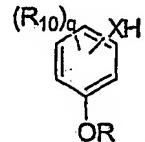
What is claimed is:

1. A method of synthesizing an antioxidant polymer, comprising the steps of
 5. a) partially etherifying a phenol derivative represented by the following structural formula:



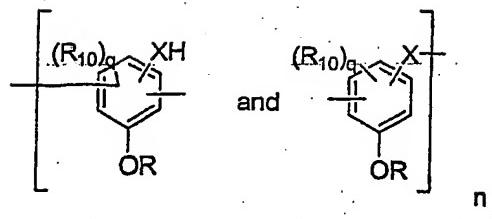
wherein:

- at least one ring carbon atom substituted with an -OH group is adjacent to one unsubstituted ring carbon atom;
- 10 X is -O-, -NH- or -S-;
- each R₁₀ is independently an optionally substituted C1-C10 alkyl group, an optionally substituted aryl group, and optionally substituted alkoxy group, an optionally substituted carbonyl group, an optionally substituted alkoxy carbonyl group, an optionally substituted aryloxycarbonyl group, -OH, -SH or -NH₂; or two R₁₀ groups on adjacent carbon atoms join together to form an optionally substituted aromatic ring or an optionally substituted carbocyclic or heterocyclic non-aromatic ring; and
- 15 20 q is an integer from 0 to 2;
- by contacting the phenol derivative with an alkyl halide, alcohol or olefin to produce an alkoxy phenol derivative represented by the following structural formula:



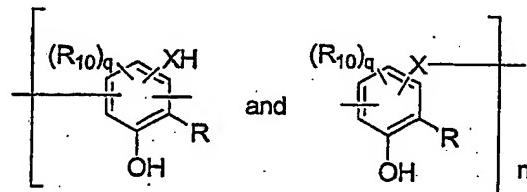
- 25 b) R is an optionally substituted C1-C10 alkyl group;
- b) polymerizing the alkoxy phenol derivative to produce an alkoxy phenol polymer comprising at least one repeat unit selected from:

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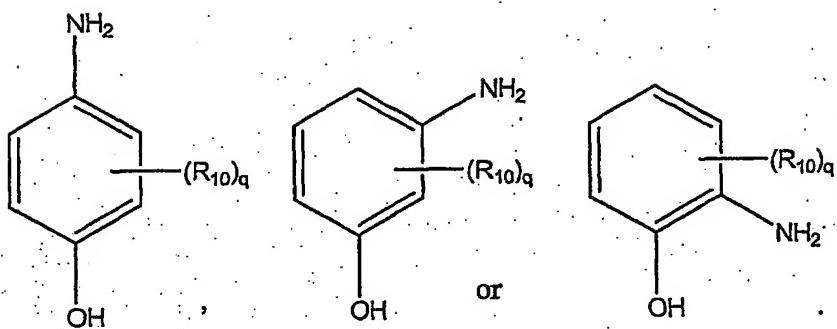
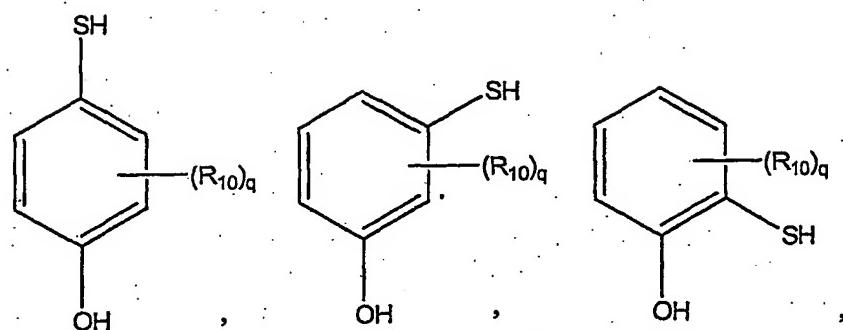
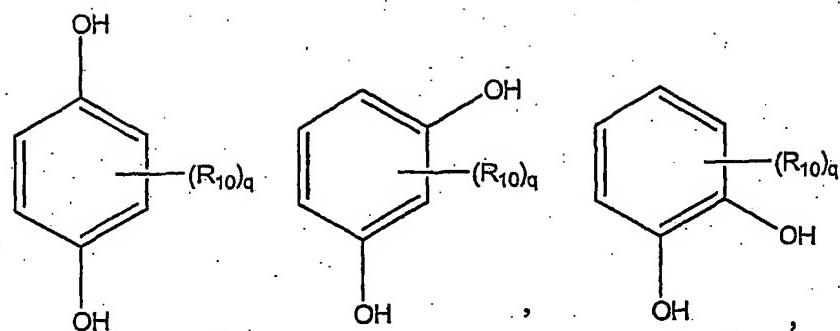
n is an integer greater than or equal to 2; and

- c) thermally rearranging the alkyl portion of the alkoxy group of the polymer repeat units to the adjacent ring carbon atom to give a
 5 polymeric alkyl phenol derivative antioxidant comprising at least one repeat unit selected from:



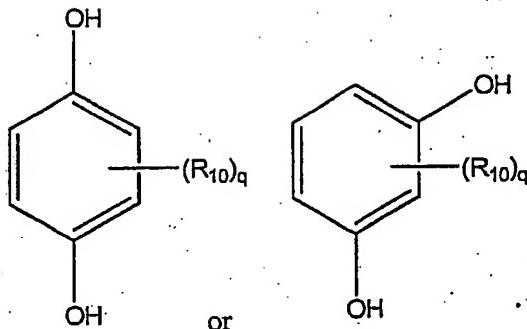
- 10 2. The method of Claim 1, wherein the phenol derivative is represented by one of the following structural formulas:

- 49 -



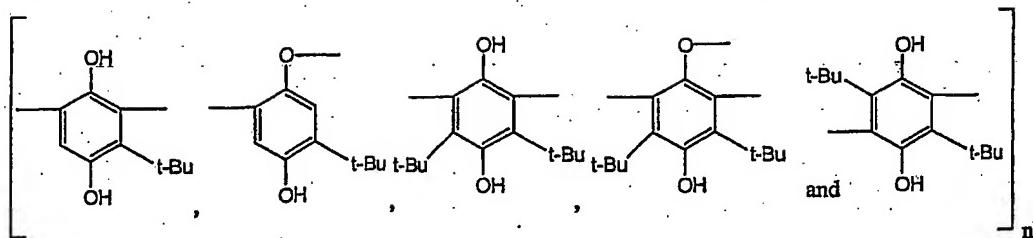
3. The method of Claim 2, wherein the phenol derivative is represented by one of the following structural formulas:

- 50 -

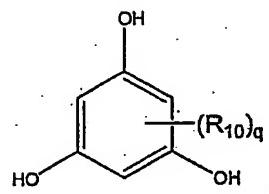


4. The method of Claim 3, wherein the etherification in step a) is carried out in
the presence of an alkyl halide and a catalyst selected from pyridine, triethyl
amine, trimethyl amine, or diethyl amine.
5. The method of Claim 3, wherein the etherification in step a) is carried out in
the presence of an alcohol or an olefin and a catalyst selected from the group
comprising an inorganic acid and a cationic exchange resin bearing sulfonic
acid groups or metal halides.
- 10 6. The method of Claim 3, wherein the polymerization in step b) is carried out
in the presence of a biocatalyst or biomimetic catalyst.
- 15 7. The method of Claim 6, wherein the biocatalyst or biomimetic catalyst is
selected from Iron(II)-salen complexes, horseradish peroxidase, soybean
peroxidase, hematin, laccase, tyroniase, or a tyroniase -model complex.
- 20 8. The method of Claim 3, wherein the thermal rearrangement in step c) is
carried out in the presence of catalyst selected from hydrofluoric acid, silica
gel or zeolites.
9. The method of Claim 3, wherein sterically hindered polymeric
macromolecular antioxidant produced in step c) comprises at least one repeat
25 unit selected from:

- 51 -



10. The method of Claim 2, wherein the phenol derivative is represented by the
5 following structural formula:



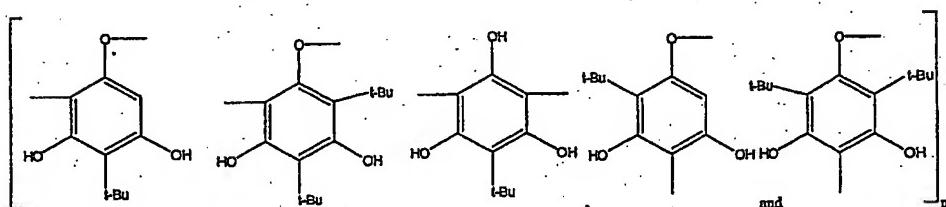
wherein:

q is 0 or 1.

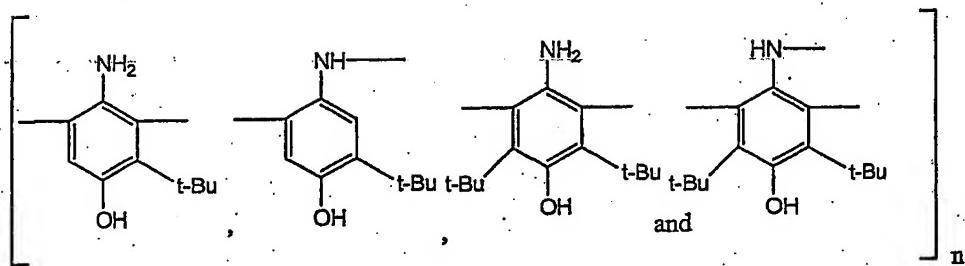
10

11. The method of Claim 10, wherein sterically hindered polymeric
macromolecular antioxidant produced in step c) comprises at least one repeat
unit selected from:

15

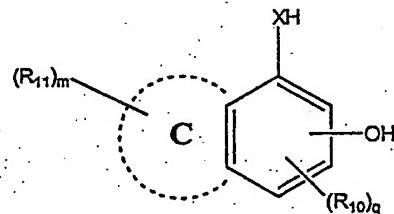


12. The method of Claim 2, wherein sterically hindered polymeric
macromolecular antioxidant produced in step c) comprises at least one repeat
unit selected from:



13. The method of Claim 1, wherein each R₁₀ is independently C1-C10 alkyl, -OH, -SH or -NH₂, or two R₁₀ groups on adjacent carbon atoms join together to form an optionally substituted aromatic ring or an optionally substituted carbocyclic or heterocyclic non-aromatic ring.
- 5
14. The method of Claim 13, wherein the phenol derivative is represented by the following structural formula:

10

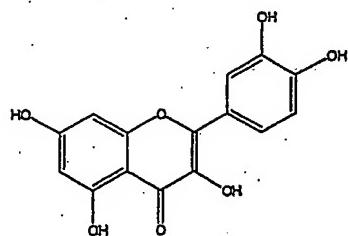


wherein:

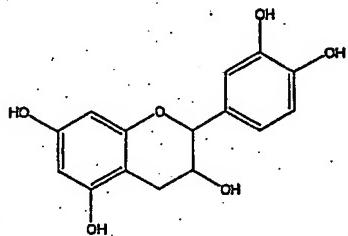
- 15 Ring C is a five or six membered aromatic or carbocyclic or heterocyclic non-aromatic ring;
- each R₁₀ is independently C1-C10 alkyl group, -OH, -SH or -NH₂;
- R₁₁ is =O, -OH, C1-C3 alkyl, optionally substituted aryl, -OC(O)(C1-C3 alkyl), -OC(O)(aryl), -OC(O)(substituted aryl), -OC(O)(aralkyl), or -OC(O)(substituted aralkyl);
- 20 q is 0 or 1; and
- m is an integer from 0 to 3.

15. The method of Claim 14, wherein Ring C is a non-aromatic heterocyclic ring.

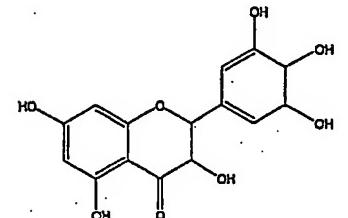
16. The method of Claim 15, wherein Ring C is tetrahydropyranyl or dihydropyranyl.
- 5 17. The method of Claim 16, wherein the phenol derivative is represented by the following structural formula:



- 10 18. The method of Claim 16, wherein the phenol derivative is represented by the following structural formula:

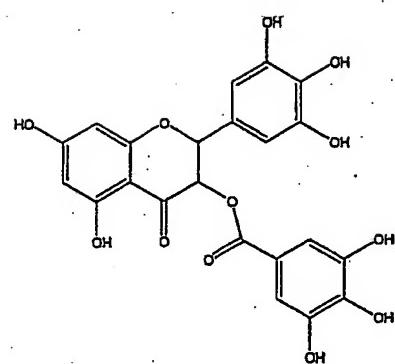


- 15 19. The method of Claim 16, wherein the phenol derivative is represented by the following structural formula:



- 20 20. The method of Claim 16, wherein the phenol derivative is represented by the following structural formula:

- 54 -



(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
8 June 2006 (08.06.2006)

PCT

(10) International Publication Number
WO 2006/060801 A3

(51) International Patent Classification:
C09K 15/04 (2006.01) C08G 61/12 (2006.01)
C08G 61/00 (2006.01)

(81) Designated States (unless otherwise indicated, for every kind of national protection available): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KM, KN, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, LY, MA, MD, MG, MK, MN, MW, MX, MZ, NA, NG, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SM, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM, ZW.

(21) International Application Number:
PCT/US2005/044021

(22) International Filing Date:
2 December 2005 (02.12.2005)

(25) Filing Language: English

(26) Publication Language: English

(30) Priority Data:
60/632,893 3 December 2004 (03.12.2004) US

(71) Applicant (for all designated States except US): POLNOX CORPORATION [US/US]; 2nd Floor, Four Cambridge Center, Cambridge, MA 02142 (US).

(72) Inventors; and

(75) Inventors/Applicants (for US only): YANG, Suizhou [CN/US]; 61 East Meadow Lane, #5, Lowell, MA 01854 (US). CHOLLI, Ashok, L. [US/US]; 6 Rosemary Lane, Chelmsford, MA 01824 (US).

(74) Agents: PIERCE, N., Scott et al.; Hamilton, Brook, Smith & Reynolds P.C., 530 Virginia Road, P.O. Box 9133, Concord, MA 01742-9133 (US).

(84) Designated States (unless otherwise indicated, for every kind of regional protection available): ARIPO (BW, GH, GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IS, IT, LT, LU, LV, MC, NL, PL, PT, RO, SE, SI, SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

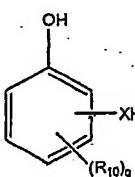
Published:

- with international search report
- before the expiration of the time limit for amending the claims and to be republished in the event of receipt of amendment(s)

(88) Date of publication of the international search report:
6 July 2006

For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.

(54) Title: PROCESS FOR THE SYNTHESIS OF POLYALKYLPHENOL ANTIOXIDANTS



(I)

(57) Abstract: Disclosed is a method for the synthesis of sterically hindered polymeric antioxidants based on phenol type antioxidant monomers. The method includes partially etherifying, polymerizing and thermally rearranging a phenol containing monomer represented by the following structural formula (I): to produce a sterically hindered polymeric macromolecular antioxidant. X, R₁₀ and q are as defined herein. The disclosed method is a simple, direct and economical process for the synthesis of sterically hindered polymeric macromolecular antioxidants.

WO 2006/060801 A3

INTERNATIONAL SEARCH REPORT

ational application No

/US2005/044021

A. CLASSIFICATION OF SUBJECT MATTER
 INV. C09K15/04 C08G61/00 C08G61/12

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

C08G C09K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the International search (name of data base and, where practical, search terms used)

EPO-Internal, WPI Data, PAJ

C. DOCUMENTS CONSIDERED TO BE RELEVANT

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A	EP 0 688 805 A (MITSUI TOATSU CHEMICALS, INCORPORATED) 27 December 1995 (1995-12-27) claims 1,6	1 -/-

 Further documents are listed in the continuation of Box C. See patent family annex.

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Date of the actual completion of the International search

Date of mailing of the International search report

12 May 2006

22/05/2006

Name and mailing address of the ISA/
 European Patent Office, P.B. 5818 Patentlaan 2
 NL - 2280 HV Rijswijk
 Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,
 Fax: (+31-70) 340-3015

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Deraedt, G

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INTERNATIONAL SEARCH REPORT

Continuation application No

/US2005/044021

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	OVERGAAG M ET AL: -"Rearrangement of alkyl phenyl ethers over dealuminated HY zeolites under liquid-phase conditions" APPLIED CATALYSIS A: GENERAL, ELSEVIER SCIENCE, AMSTERDAM, NL, vol. 175, no. 1-2, 14 December 1998 (1998-12-14), pages 139-146, XP004271571 ISSN: 0926-860X page 144, right-hand column, paragraph 2	1
A	US 4 447 657 A (FIRTH ET AL) 8 May 1984 (1984-05-08) column 1, line 66 - column 2, line 7; claims	1
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INTERNATIONAL SEARCH REPORT

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